

FIG. 1

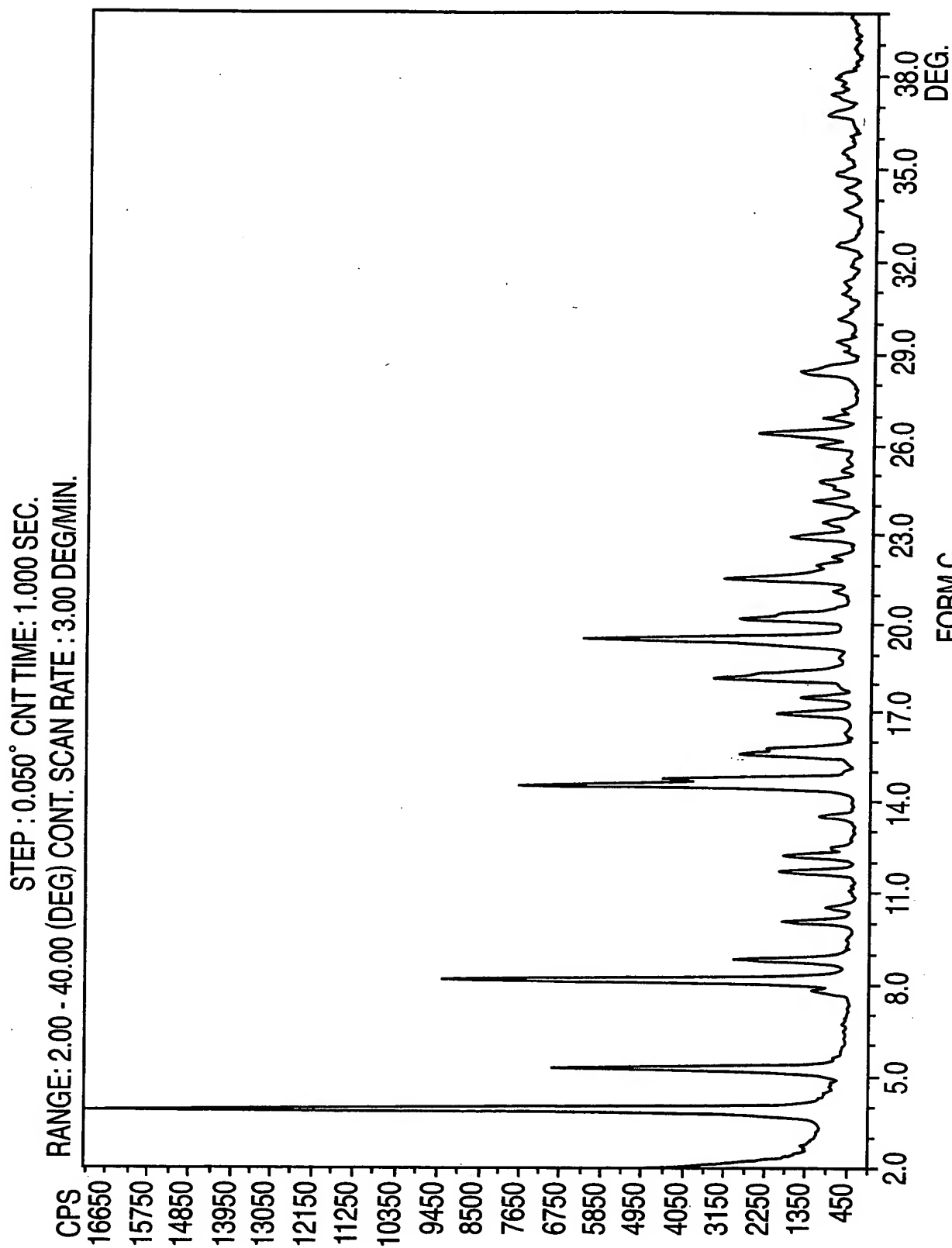


FIG. 2

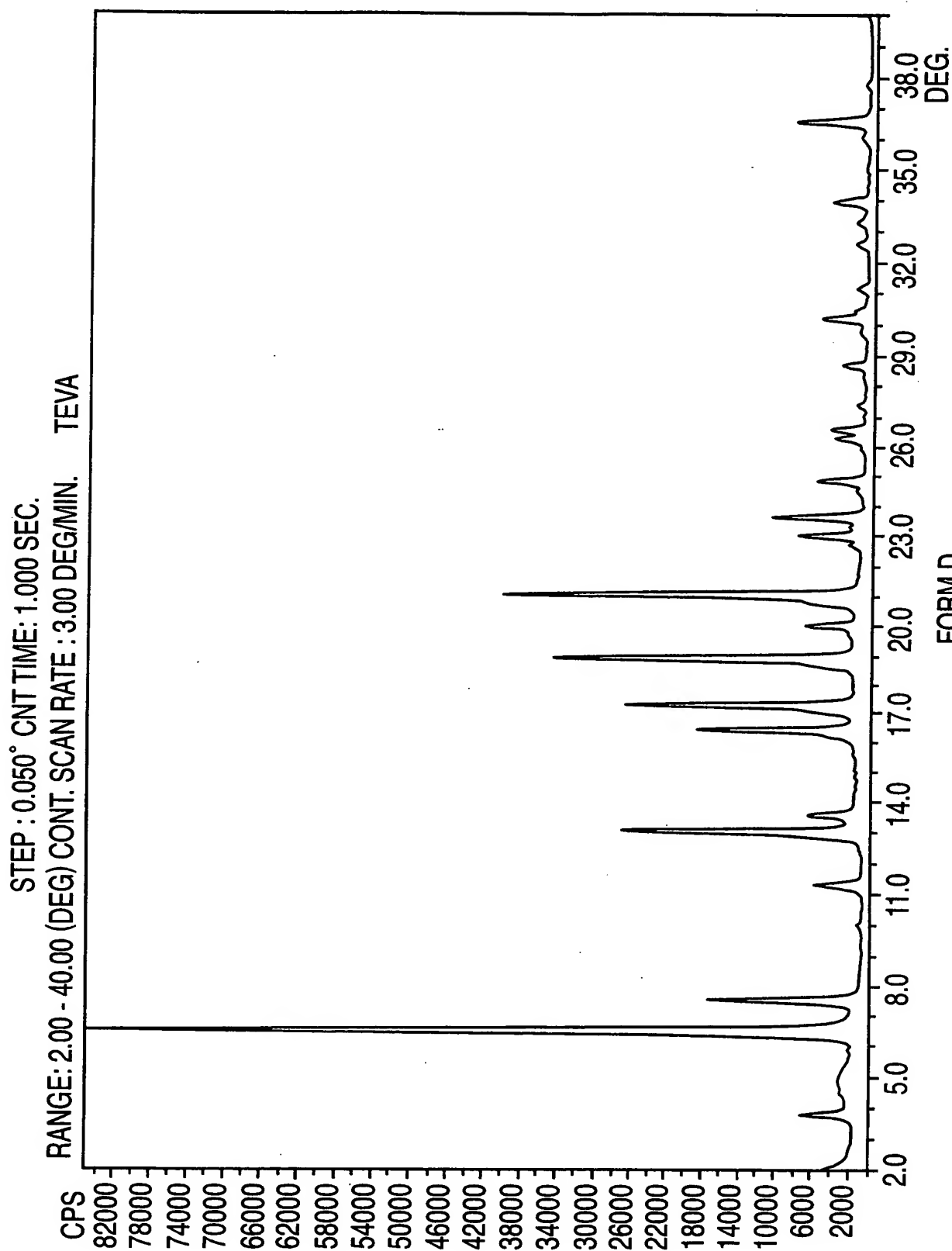
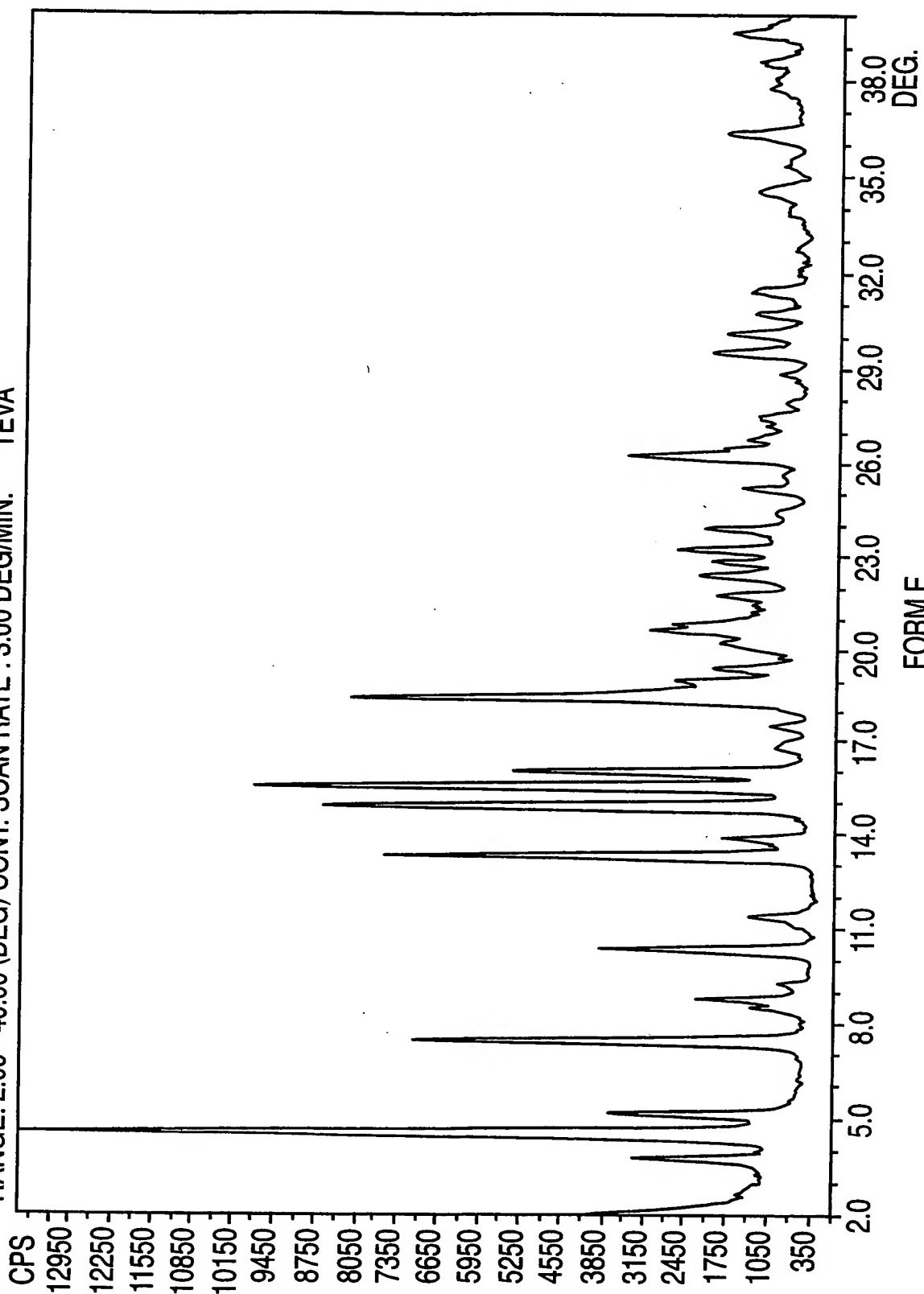


FIG. 3

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN. TEVA



FORM E
FIG. 4

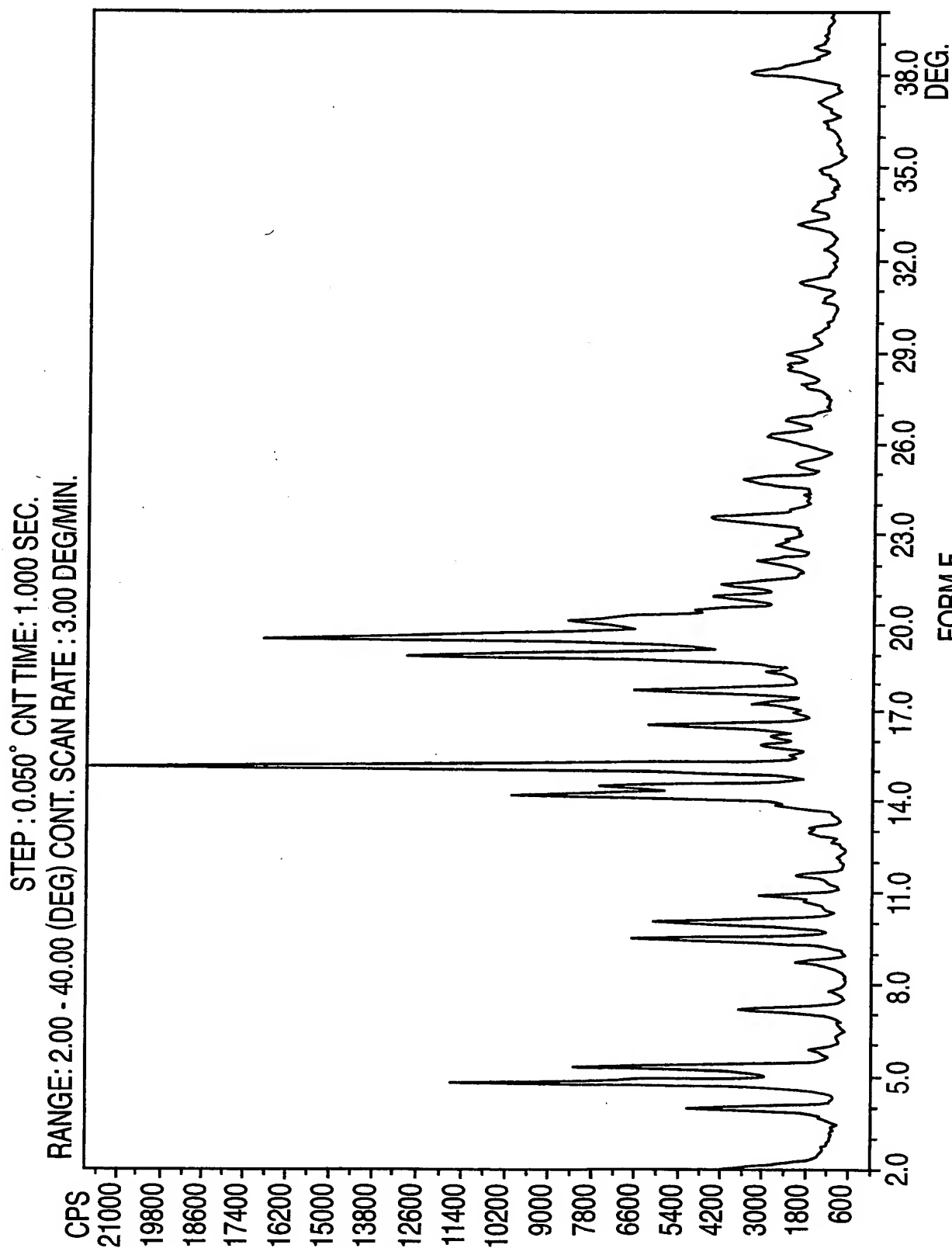
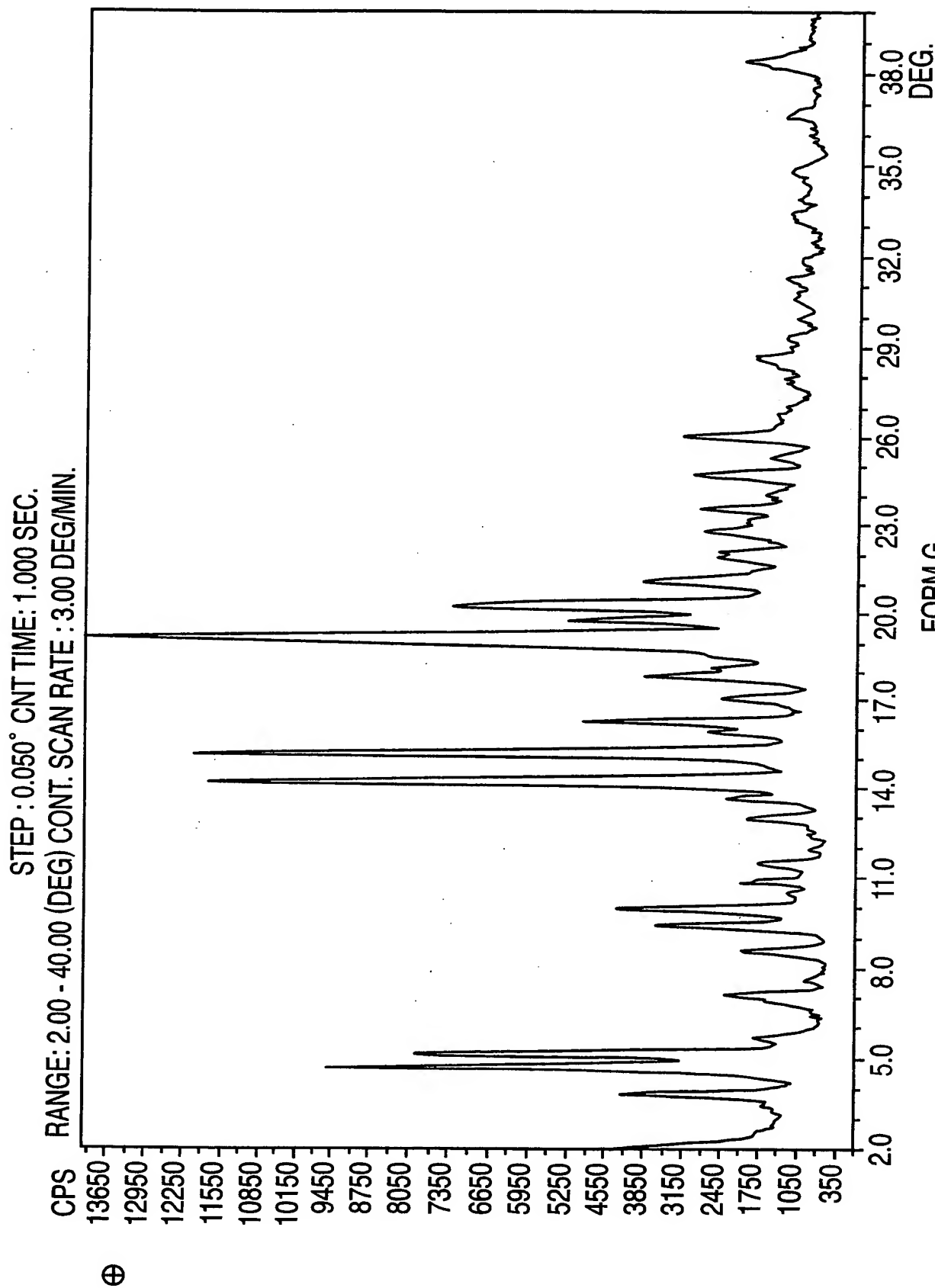
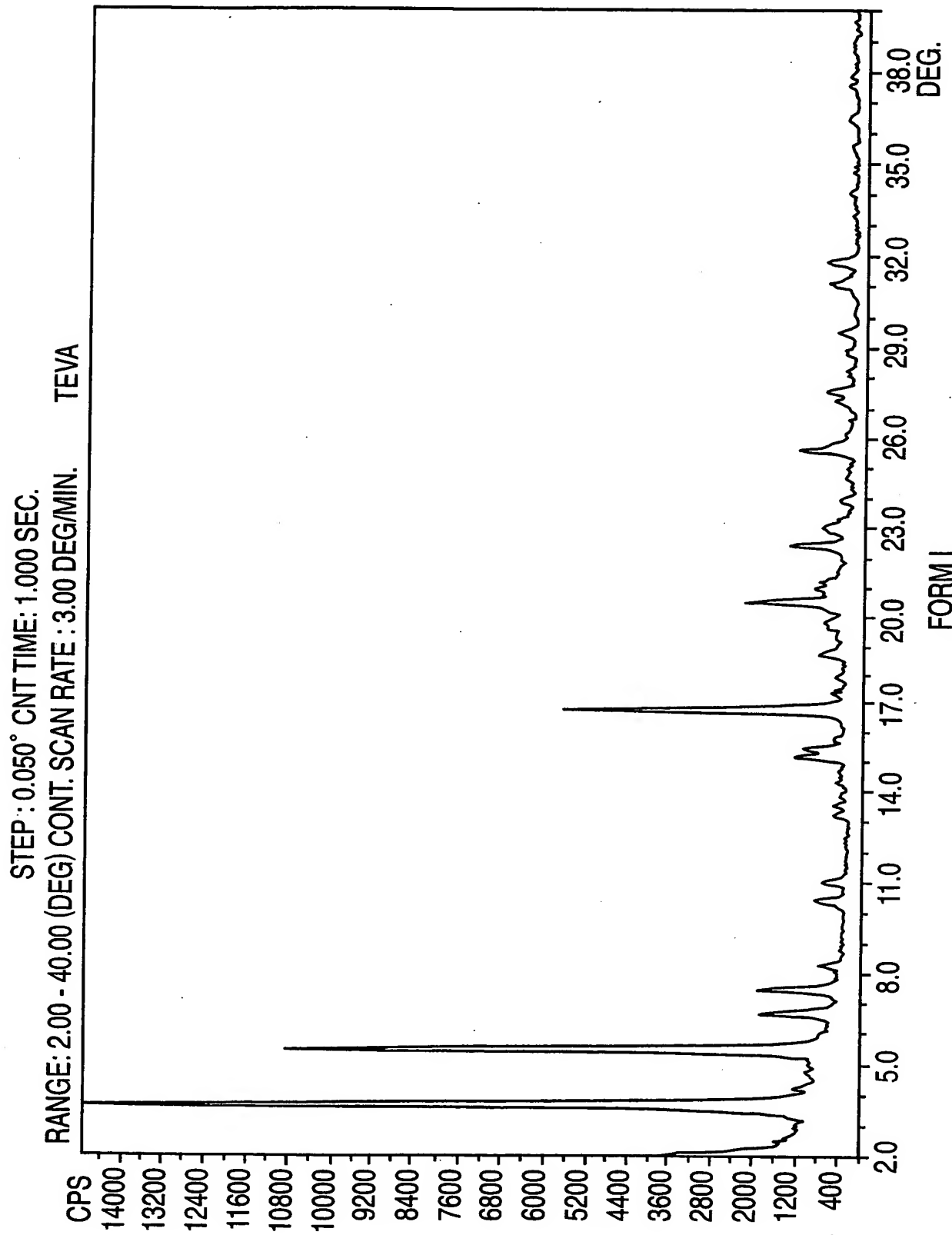


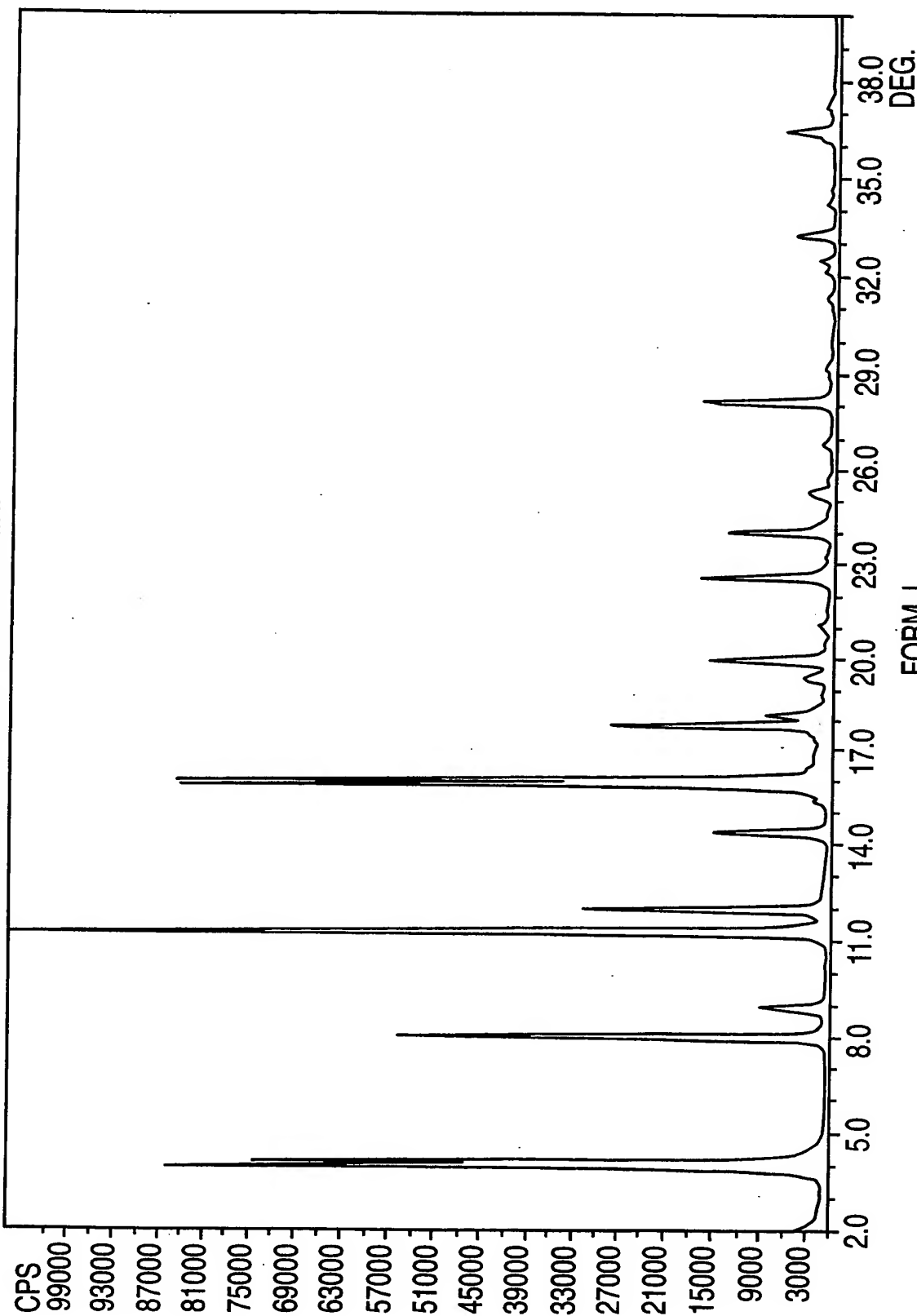
FIG. 5





FORM I
FIG. 7

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM J
FIG. 8

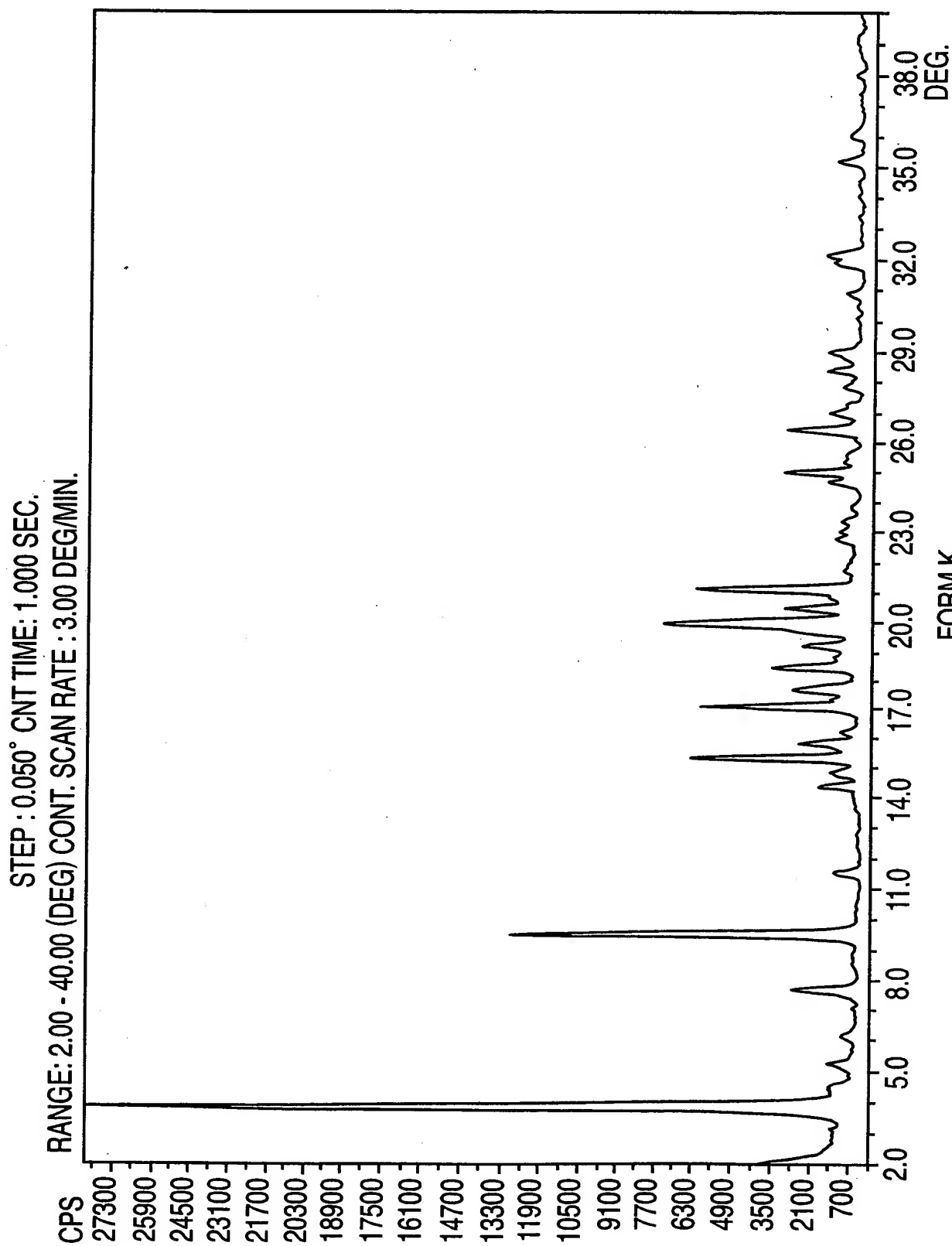


FIG. 9

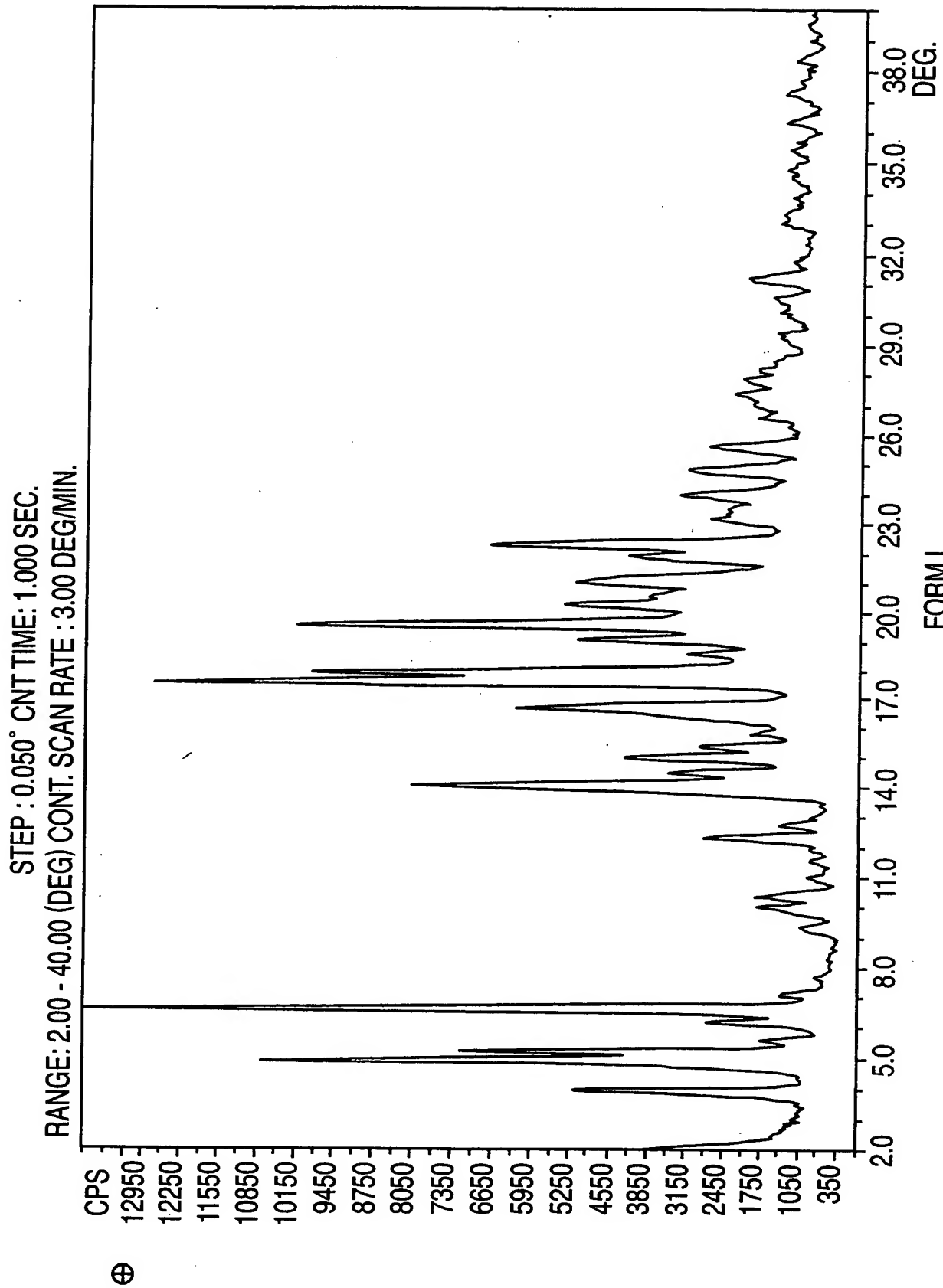
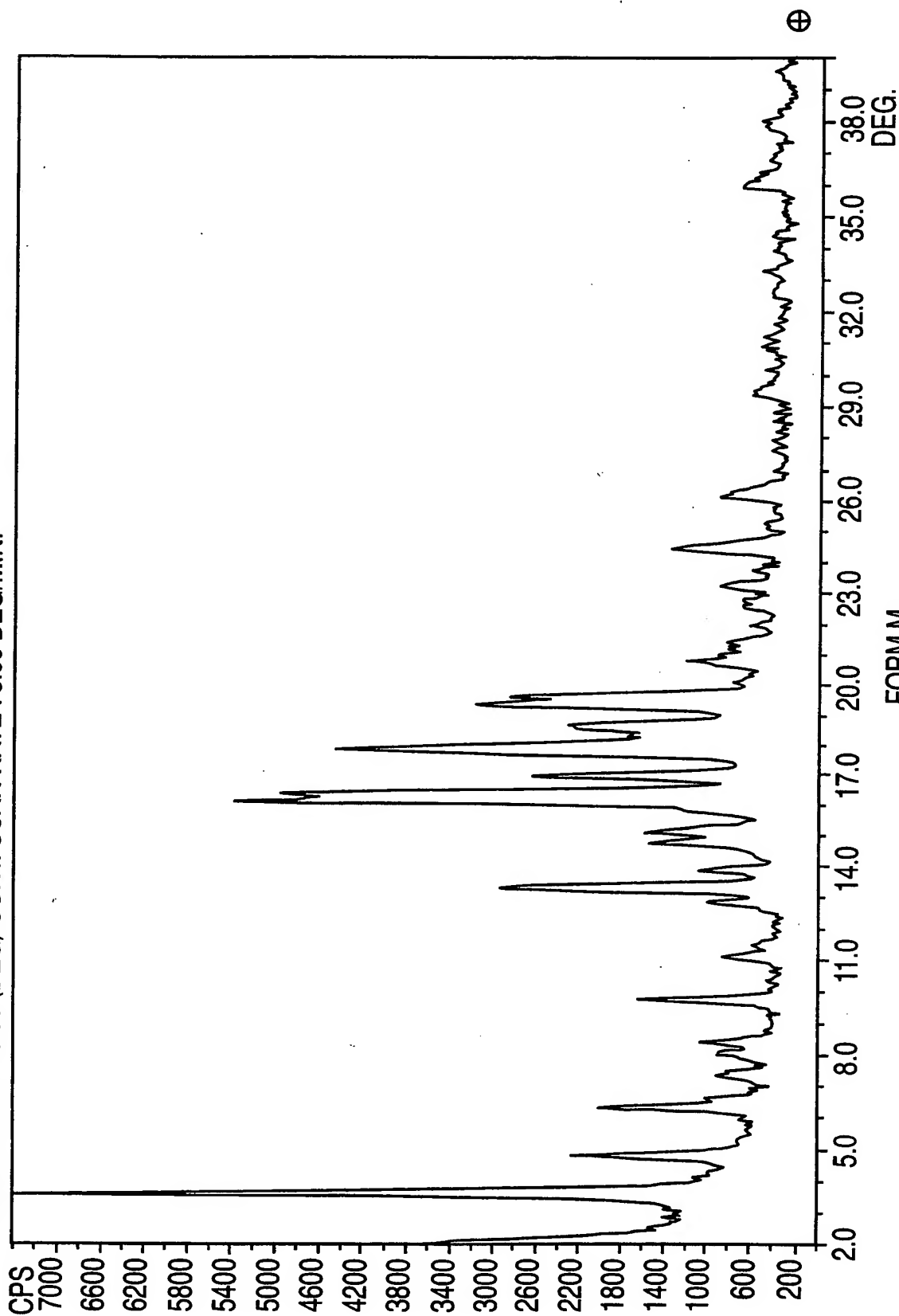


FIG. 10

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM M

FIG. 11

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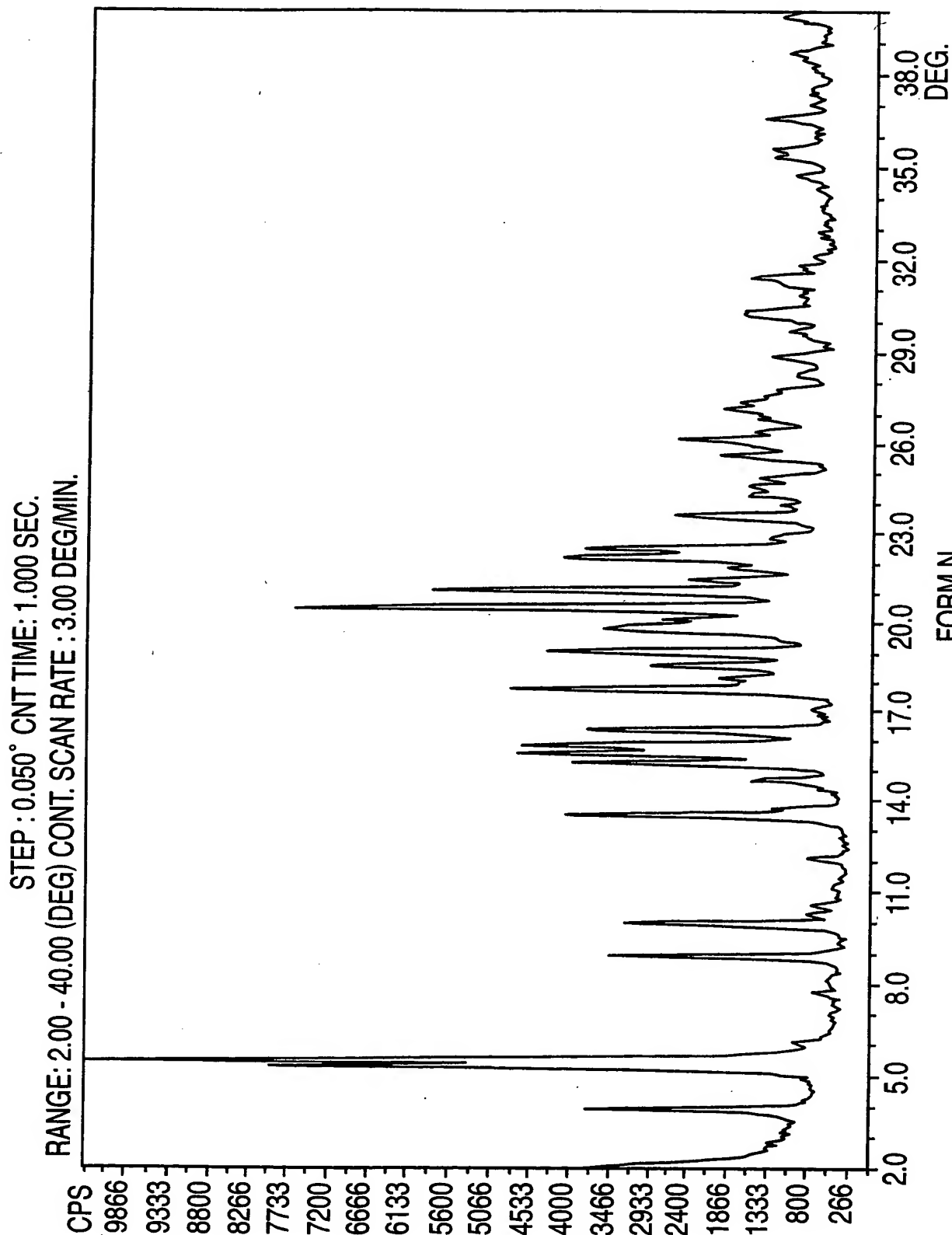
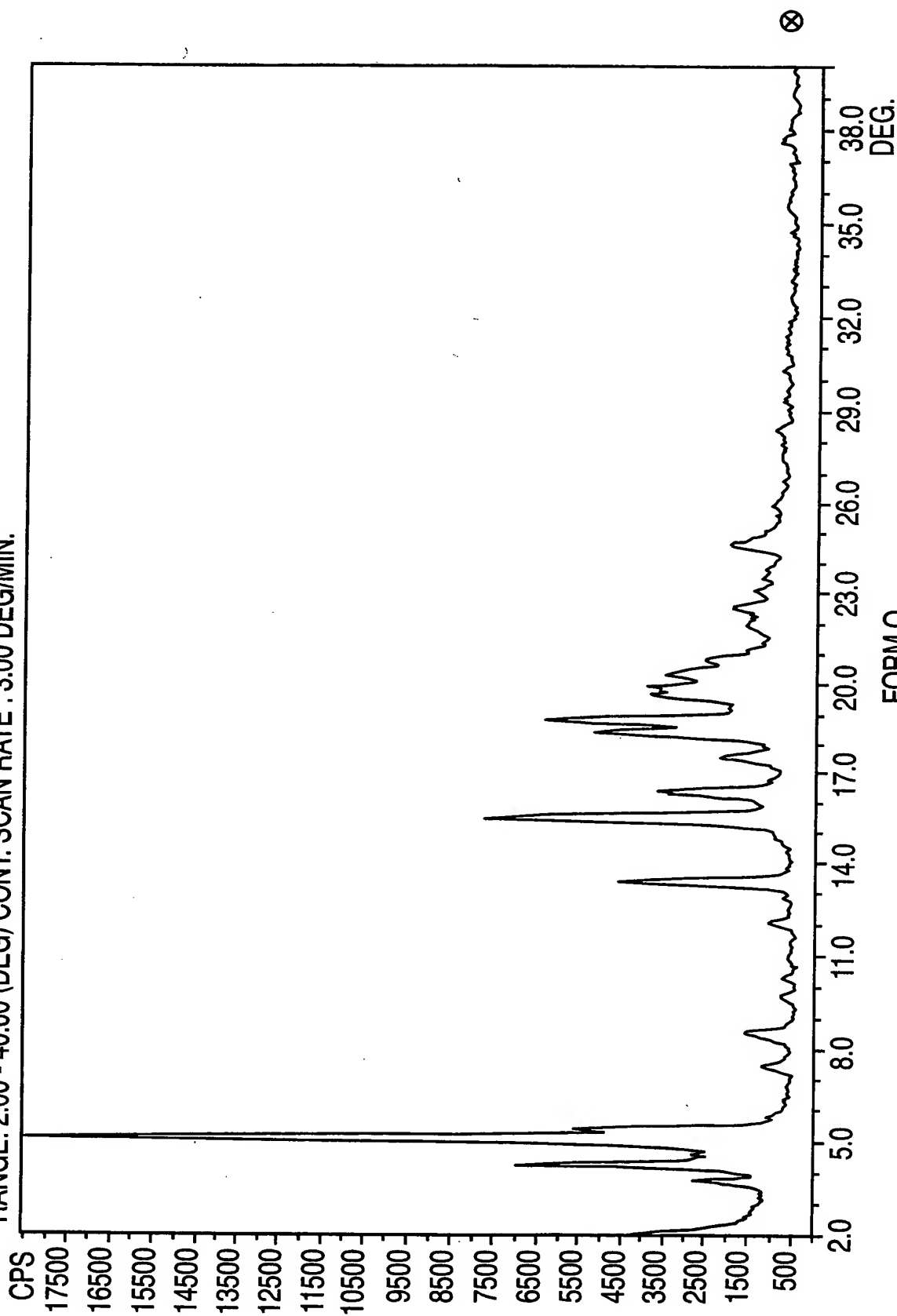


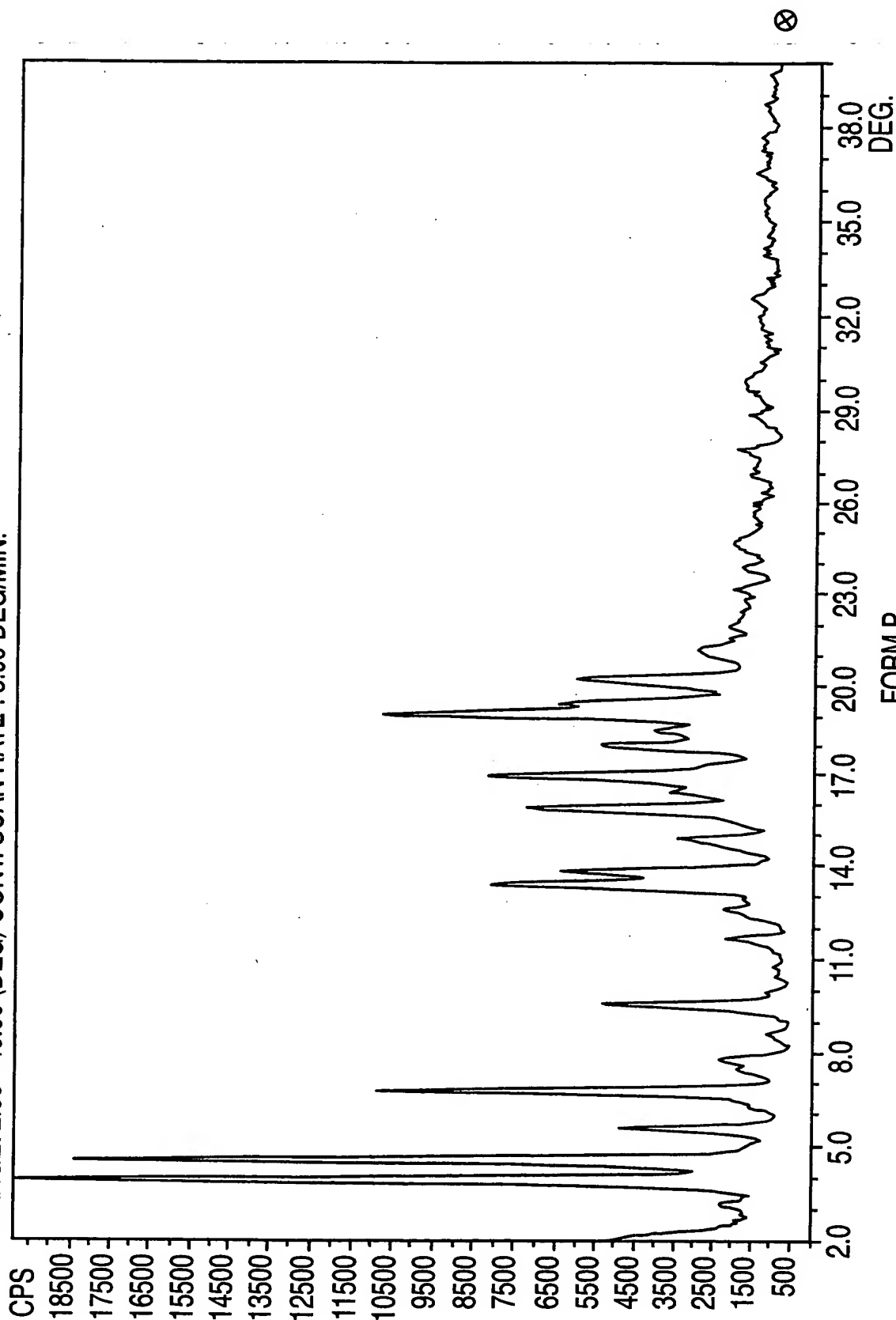
FIG. 12

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



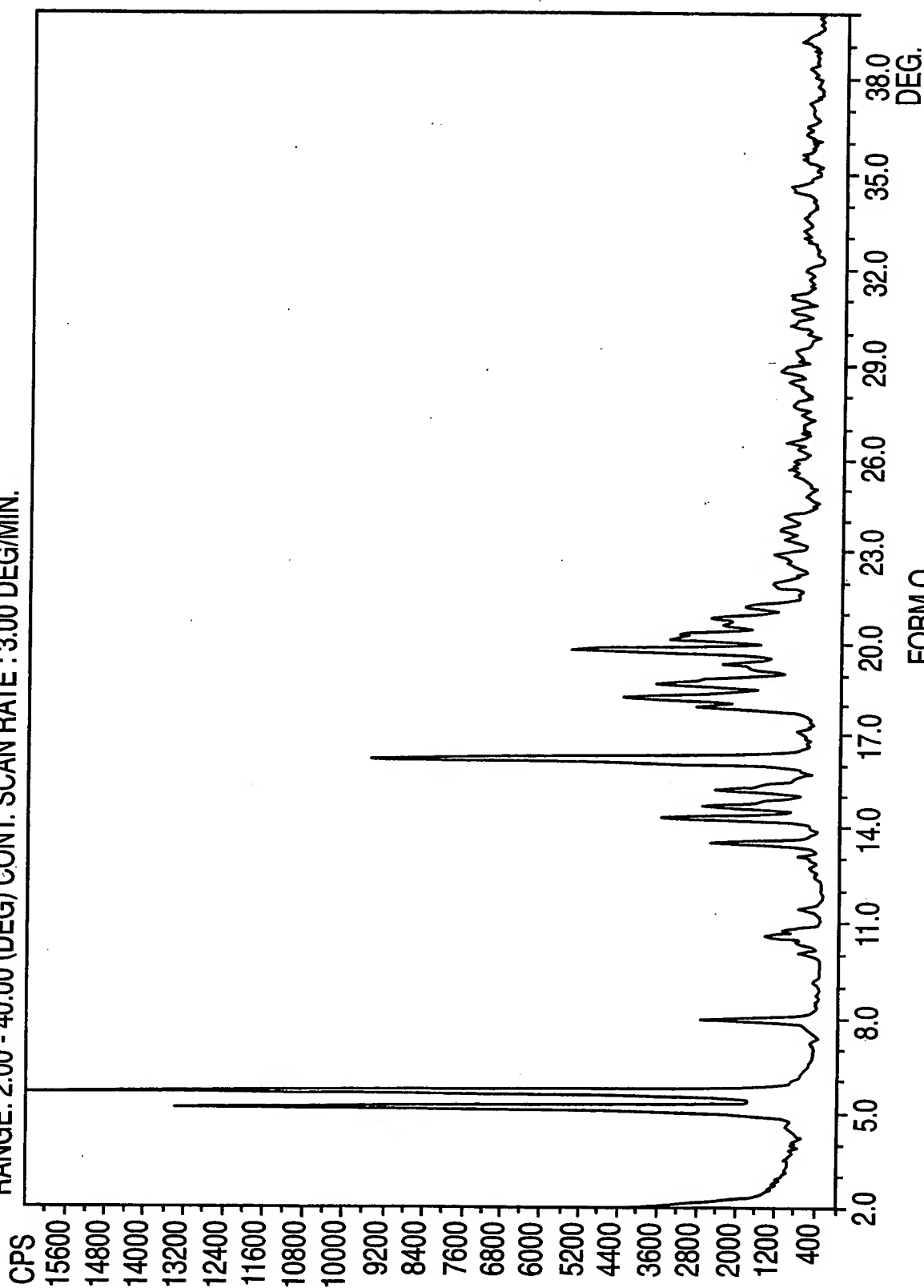
FORM 0
FIG. 13

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



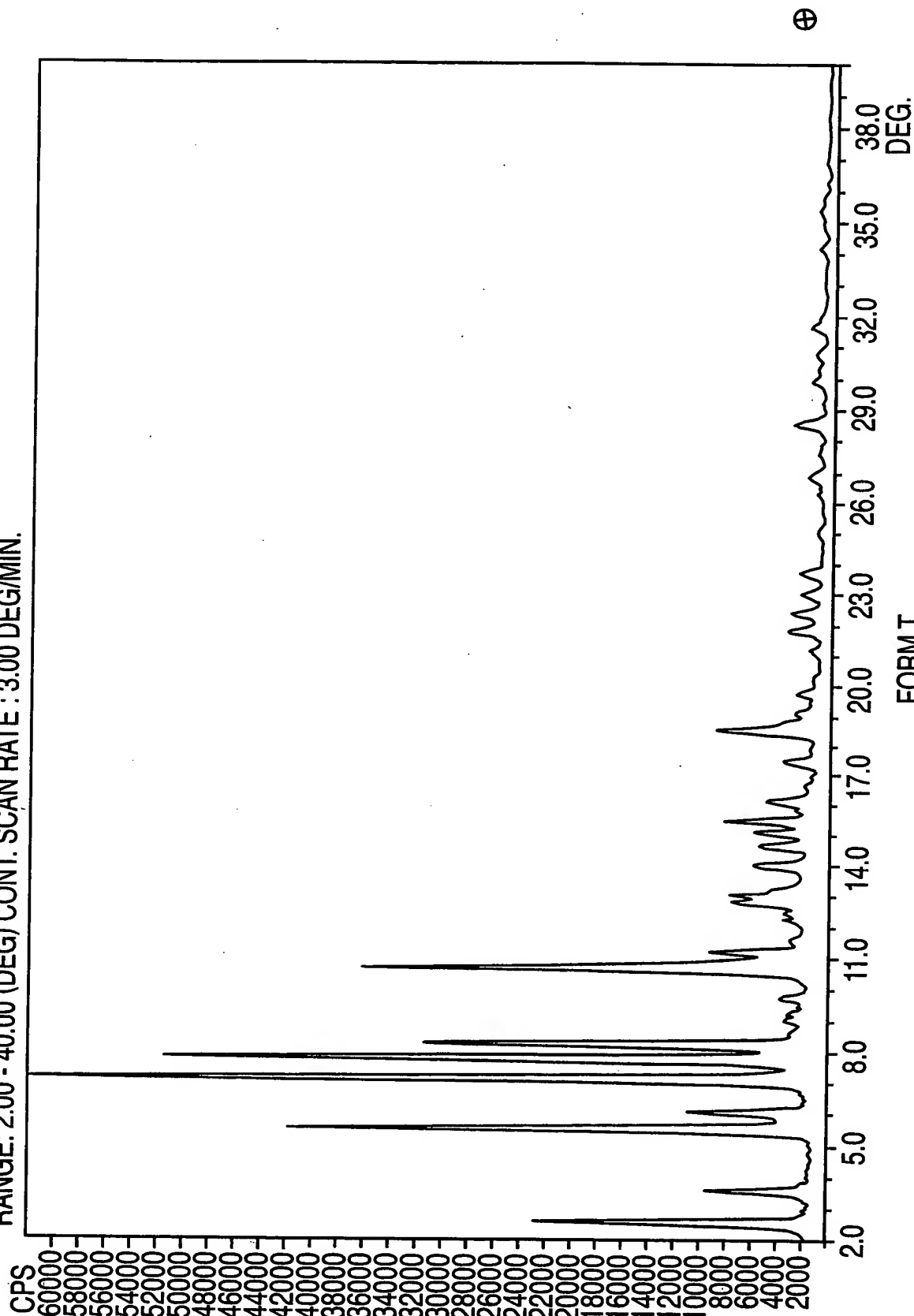
FORM P
FIG. 14

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM Q
FIG. 15

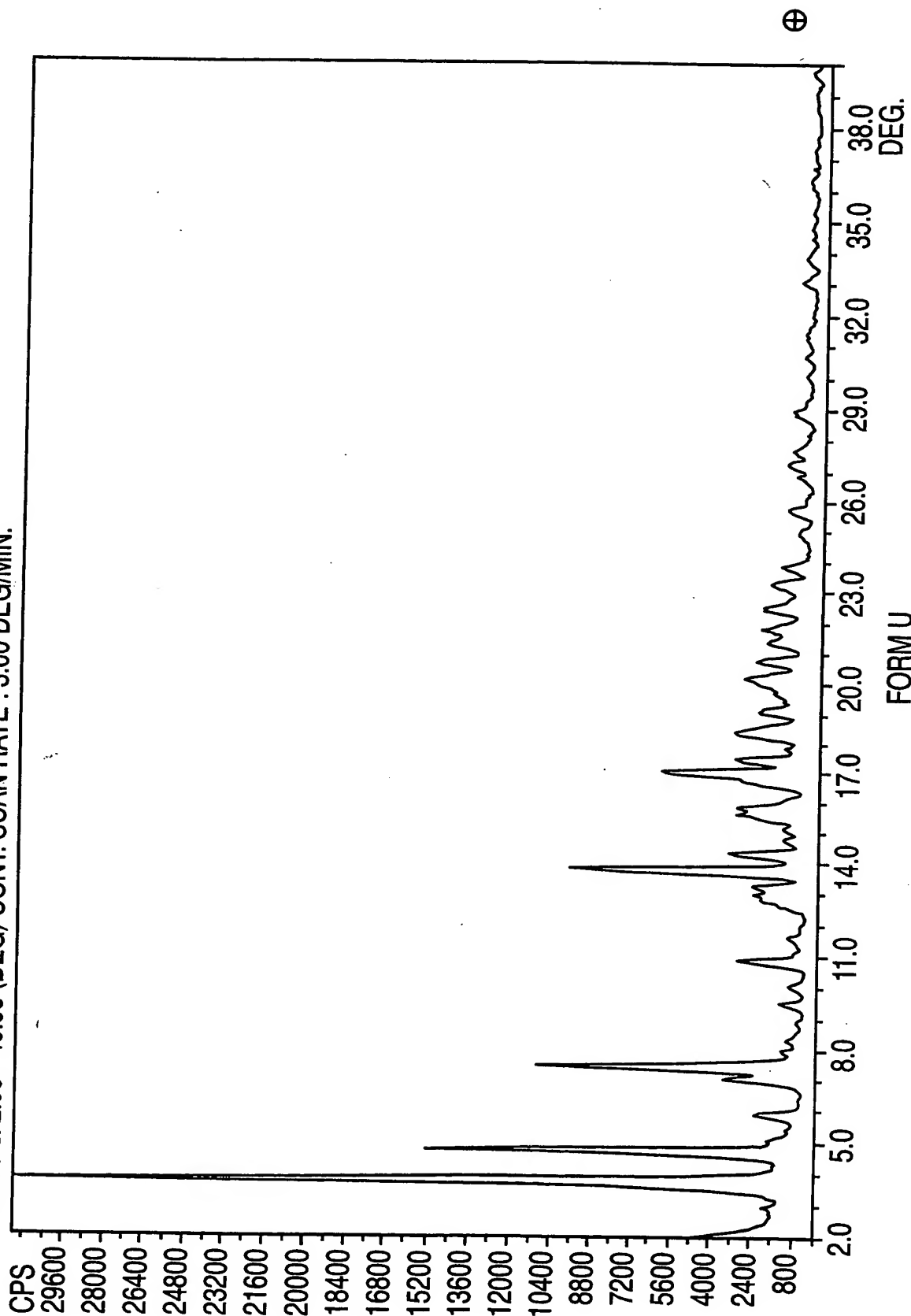
STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM T
FIG. 16

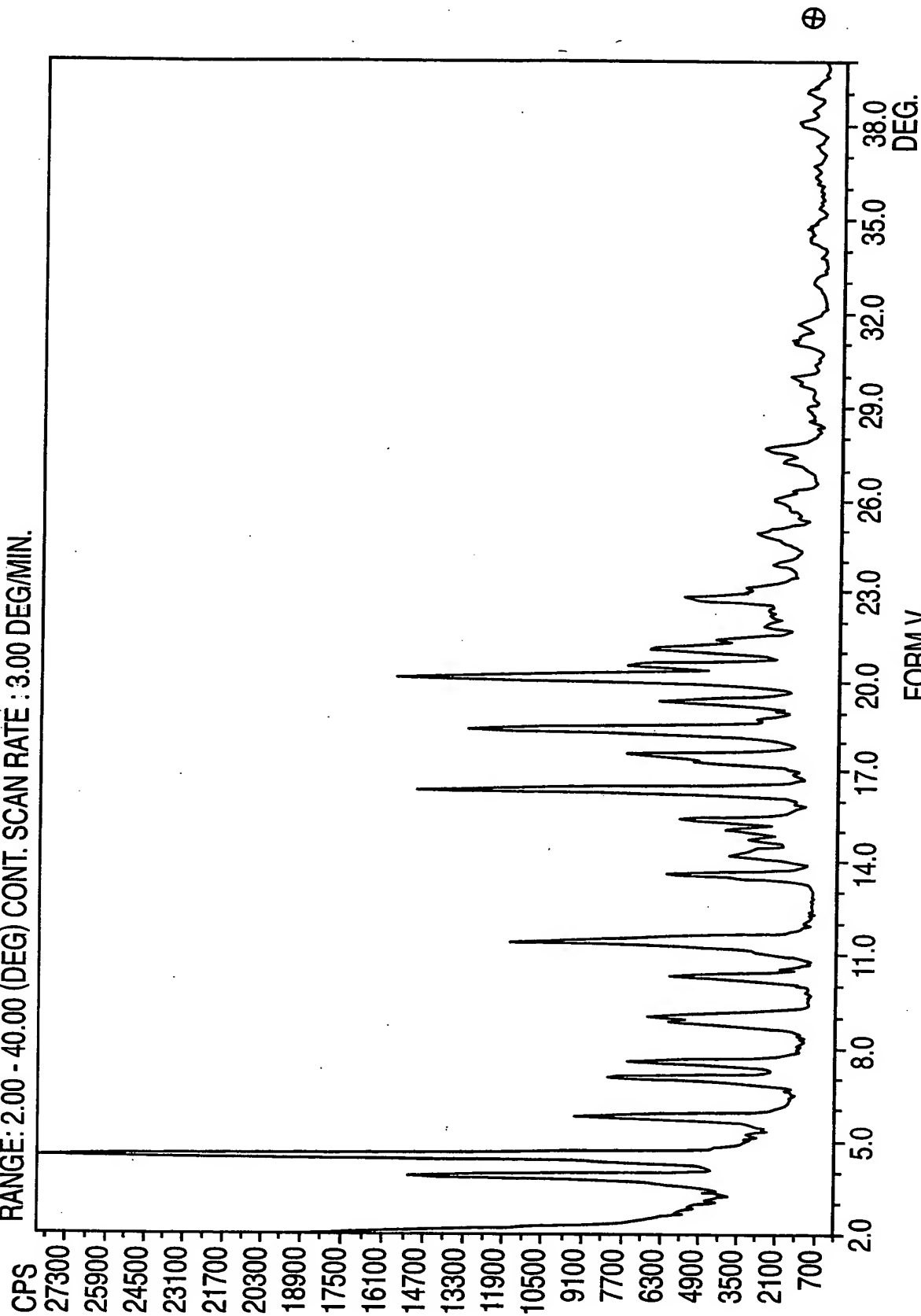
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STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM U
FIG. 17

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM V

FIG. 18

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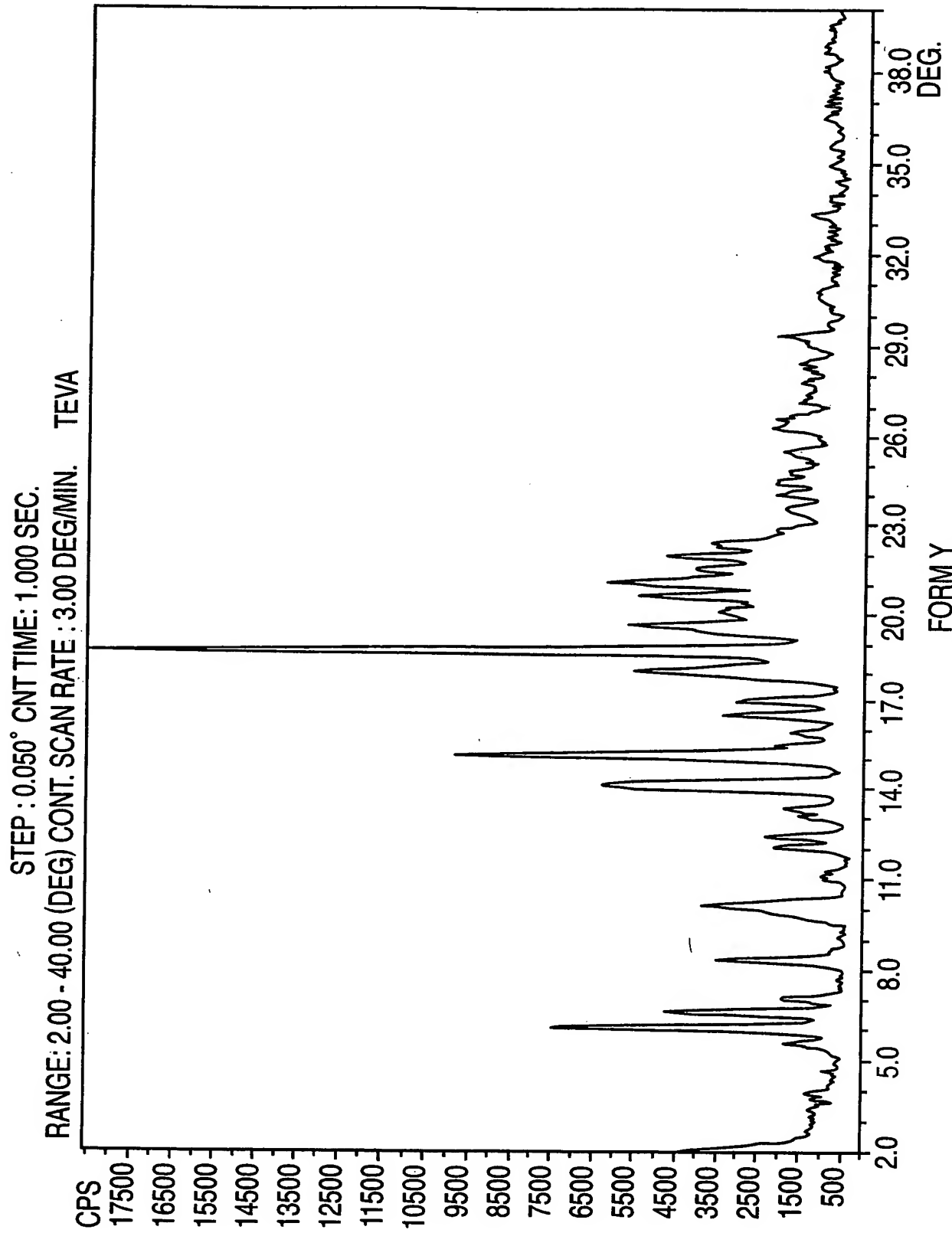


FIG. 19

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

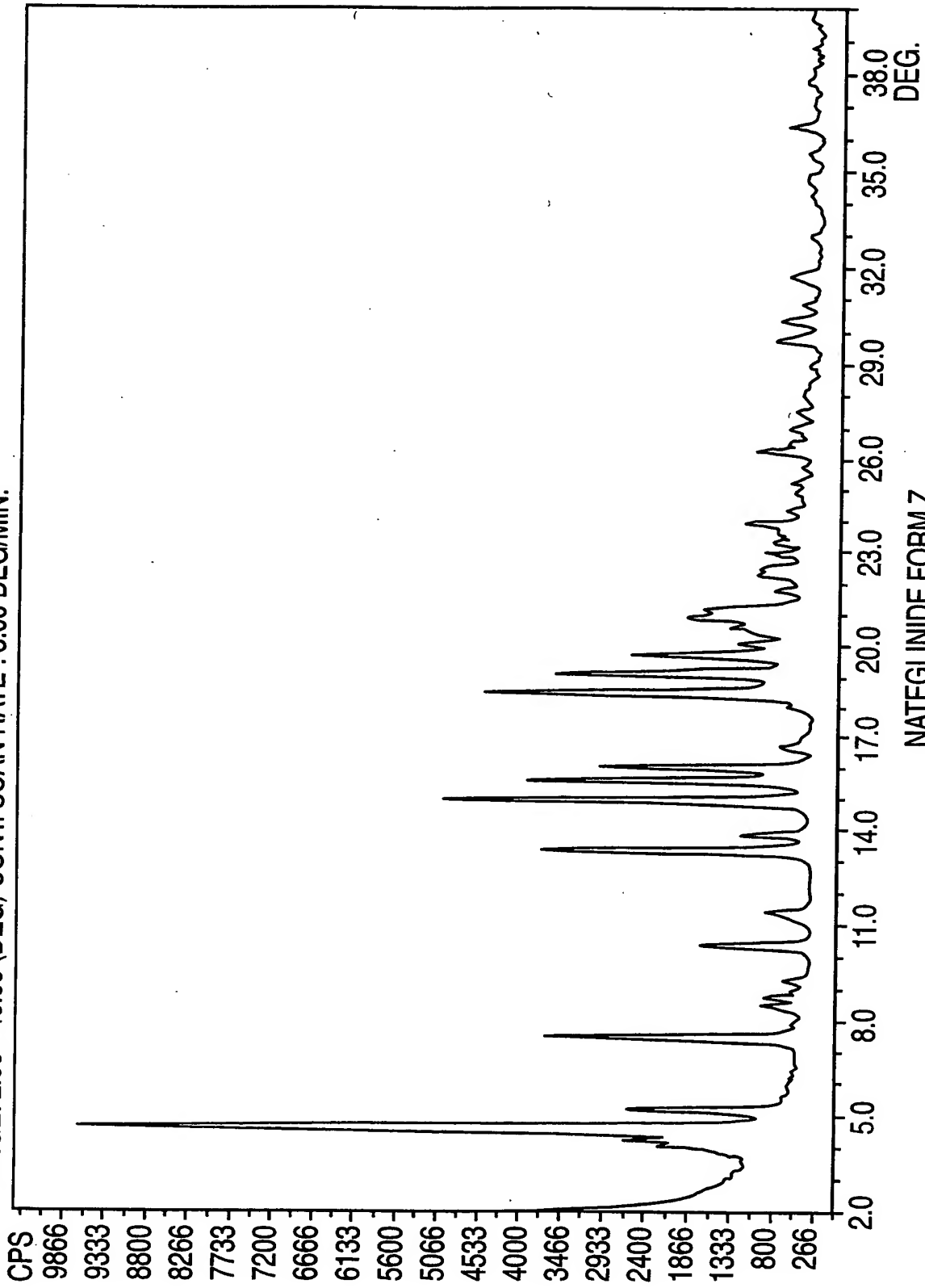


FIG. 20

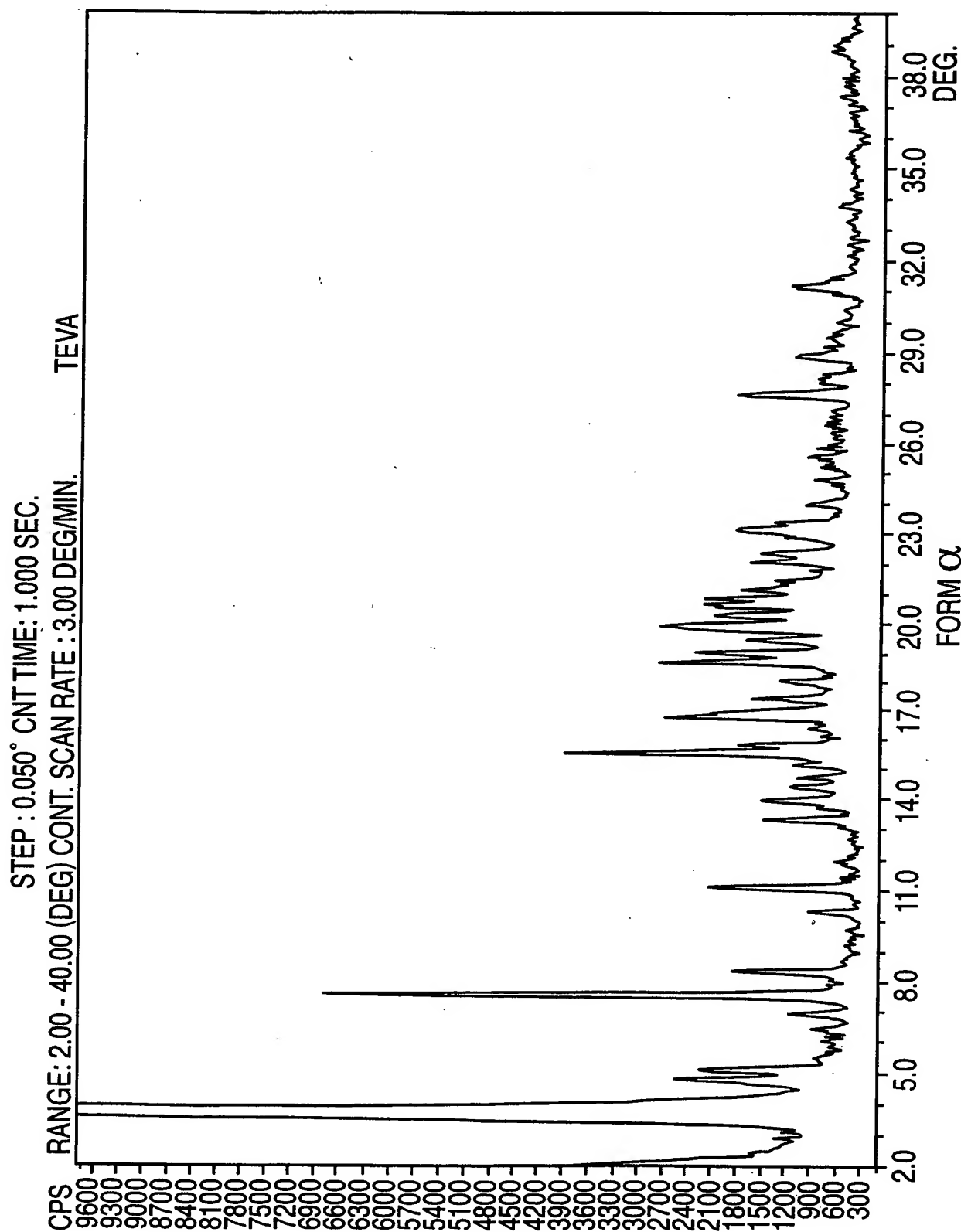


FIG. 21

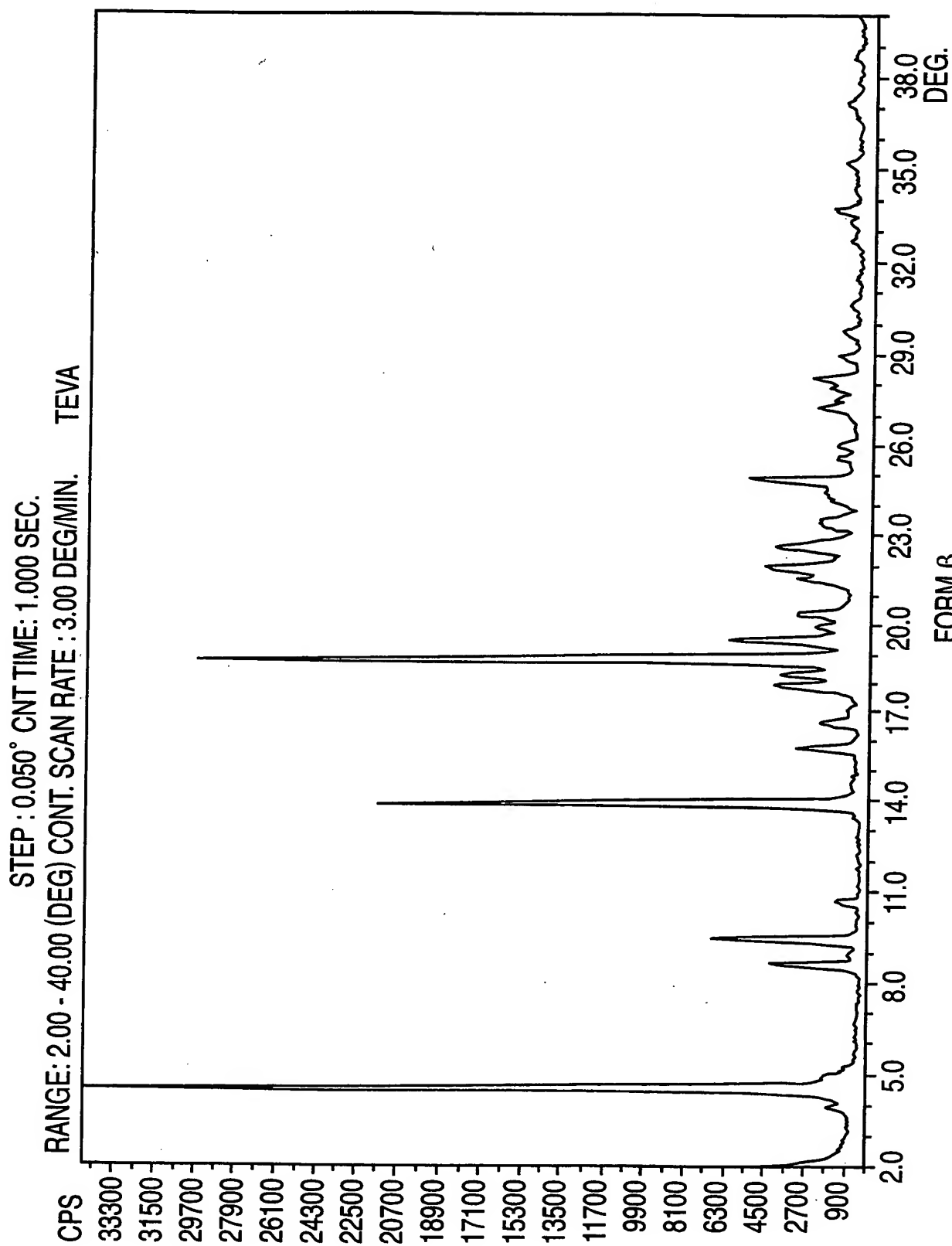


FIG. 22

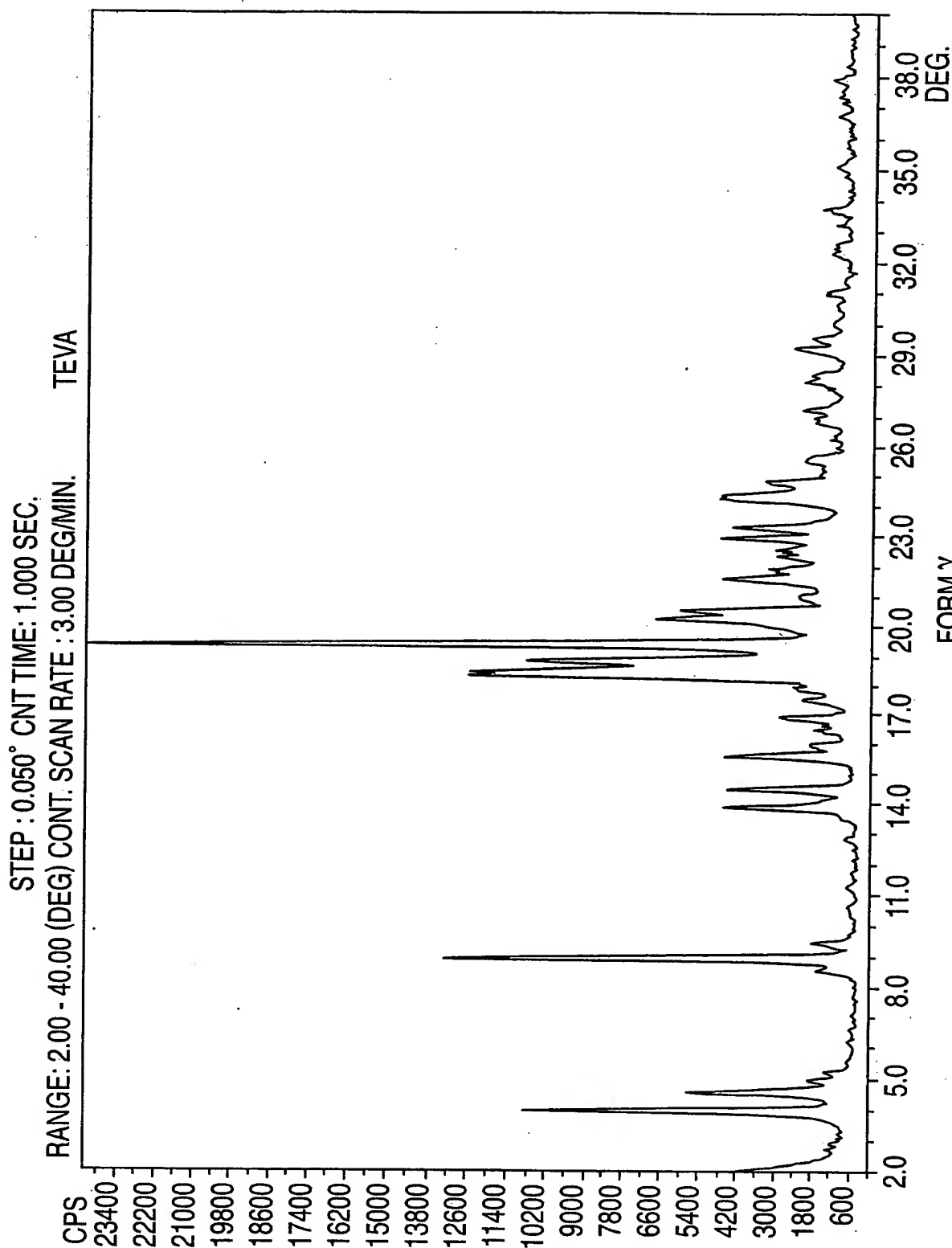


FIG. 23

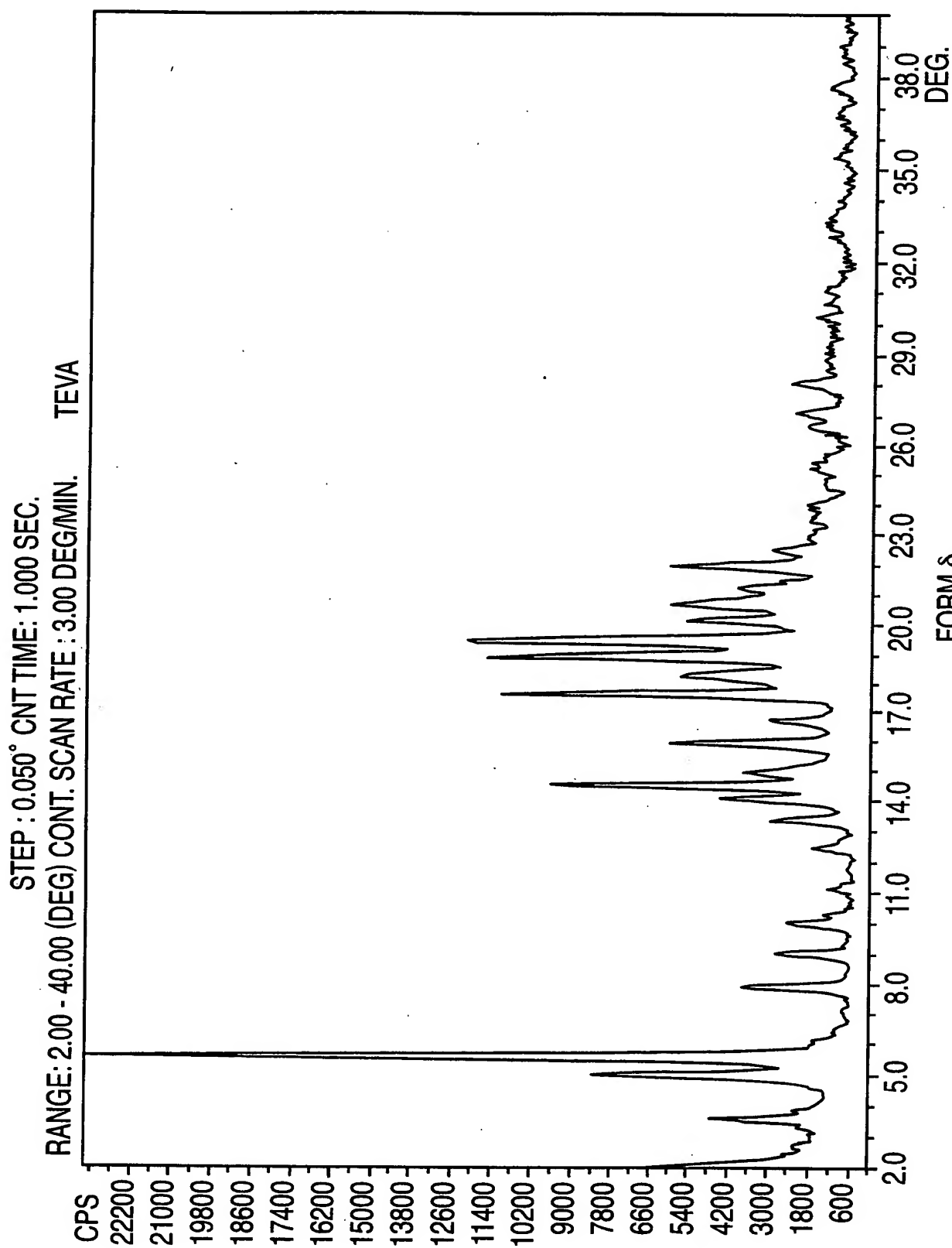


FIG. 24

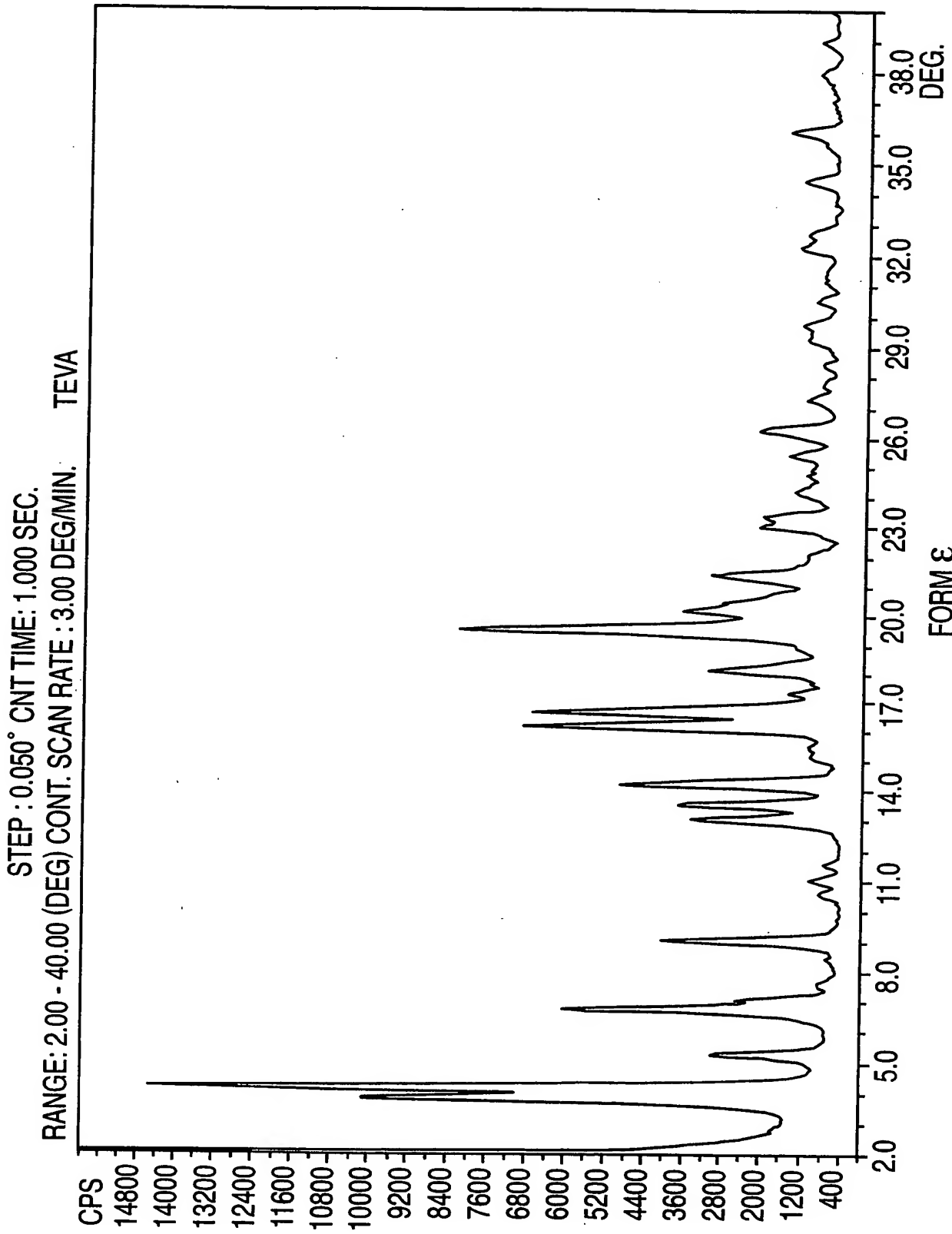


FIG. 25

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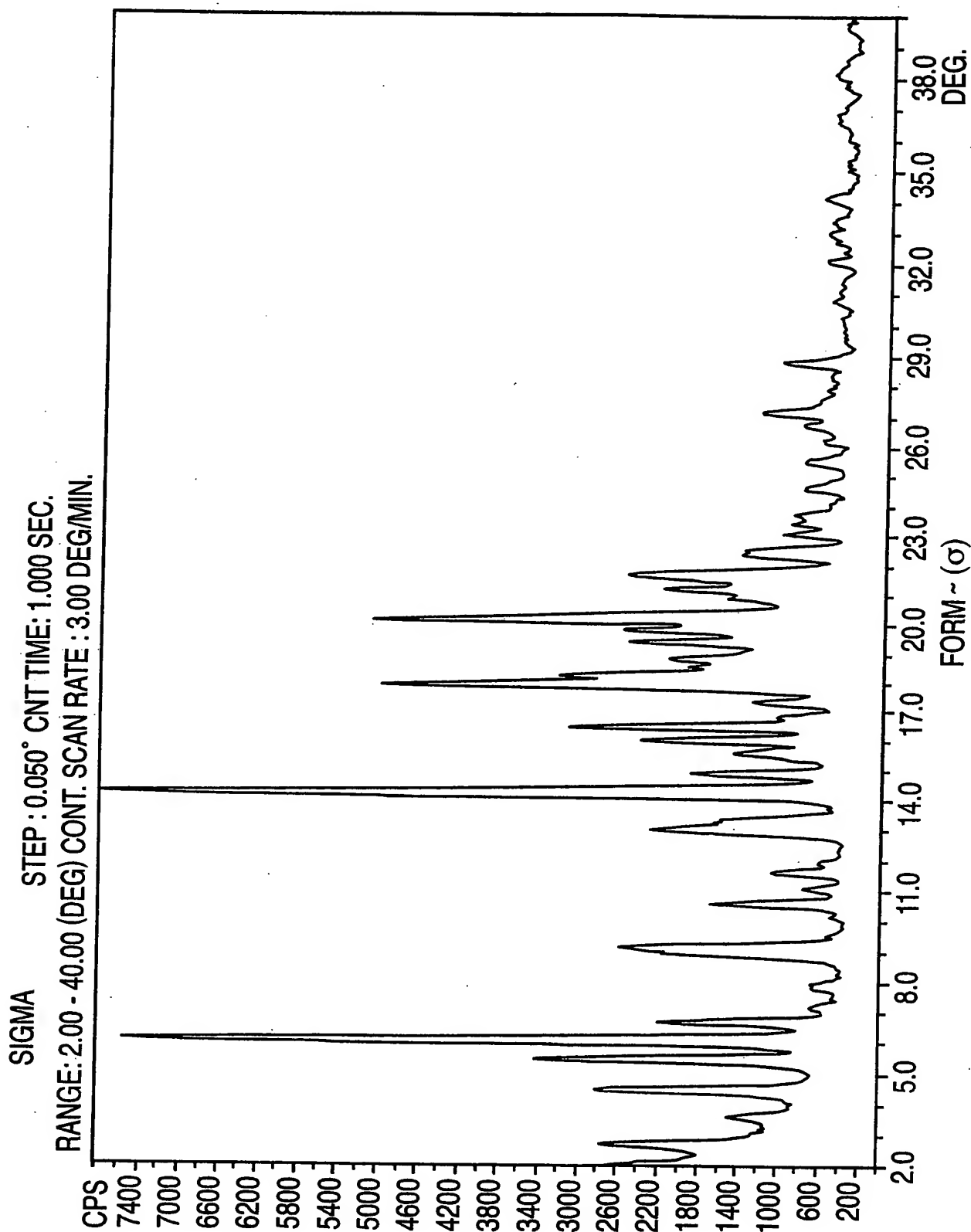


FIG. 26

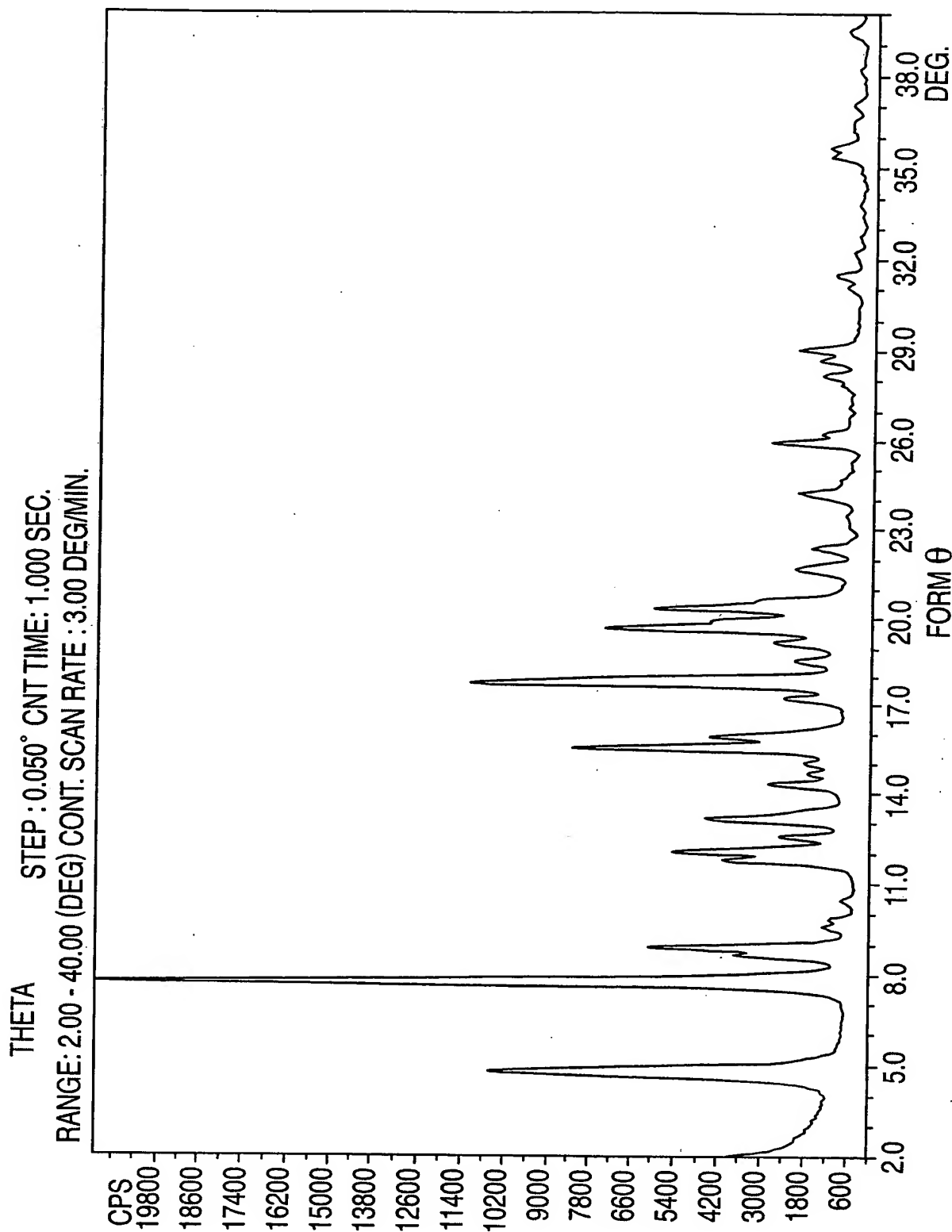
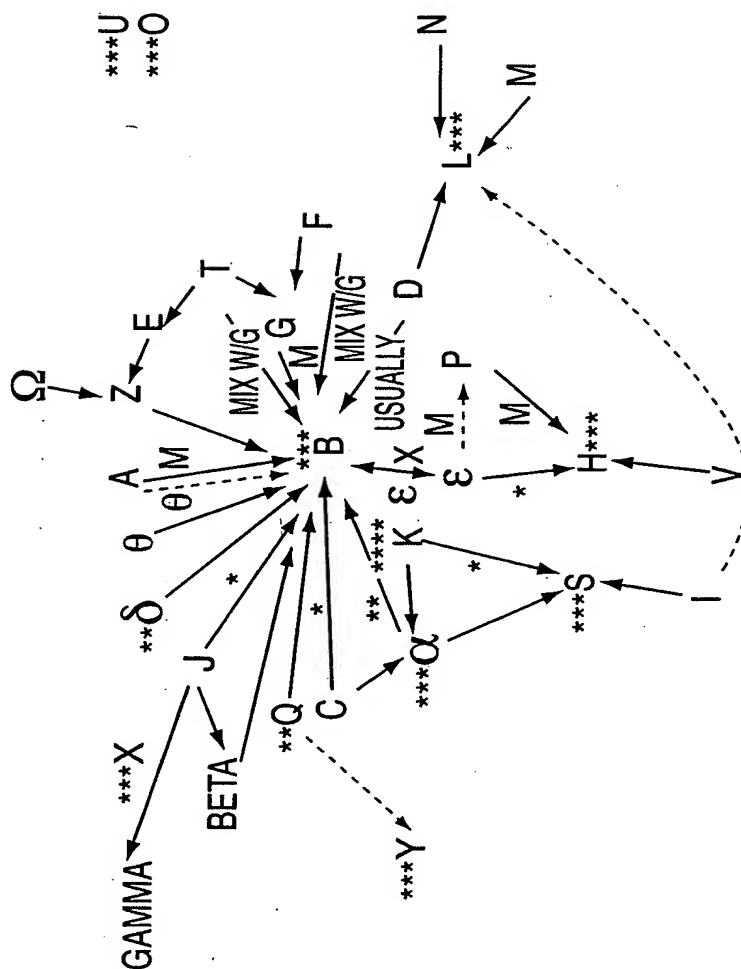


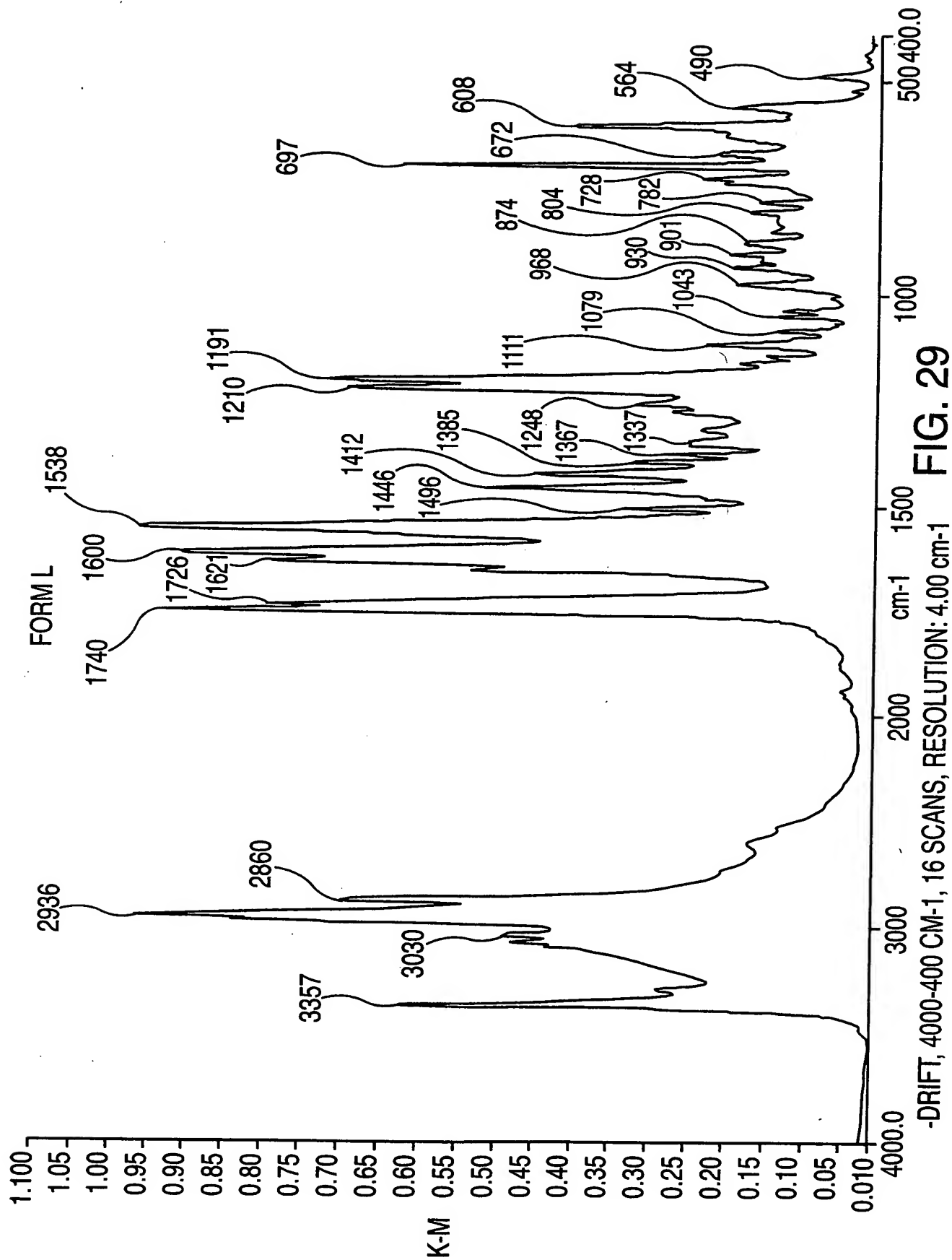
FIG. 27

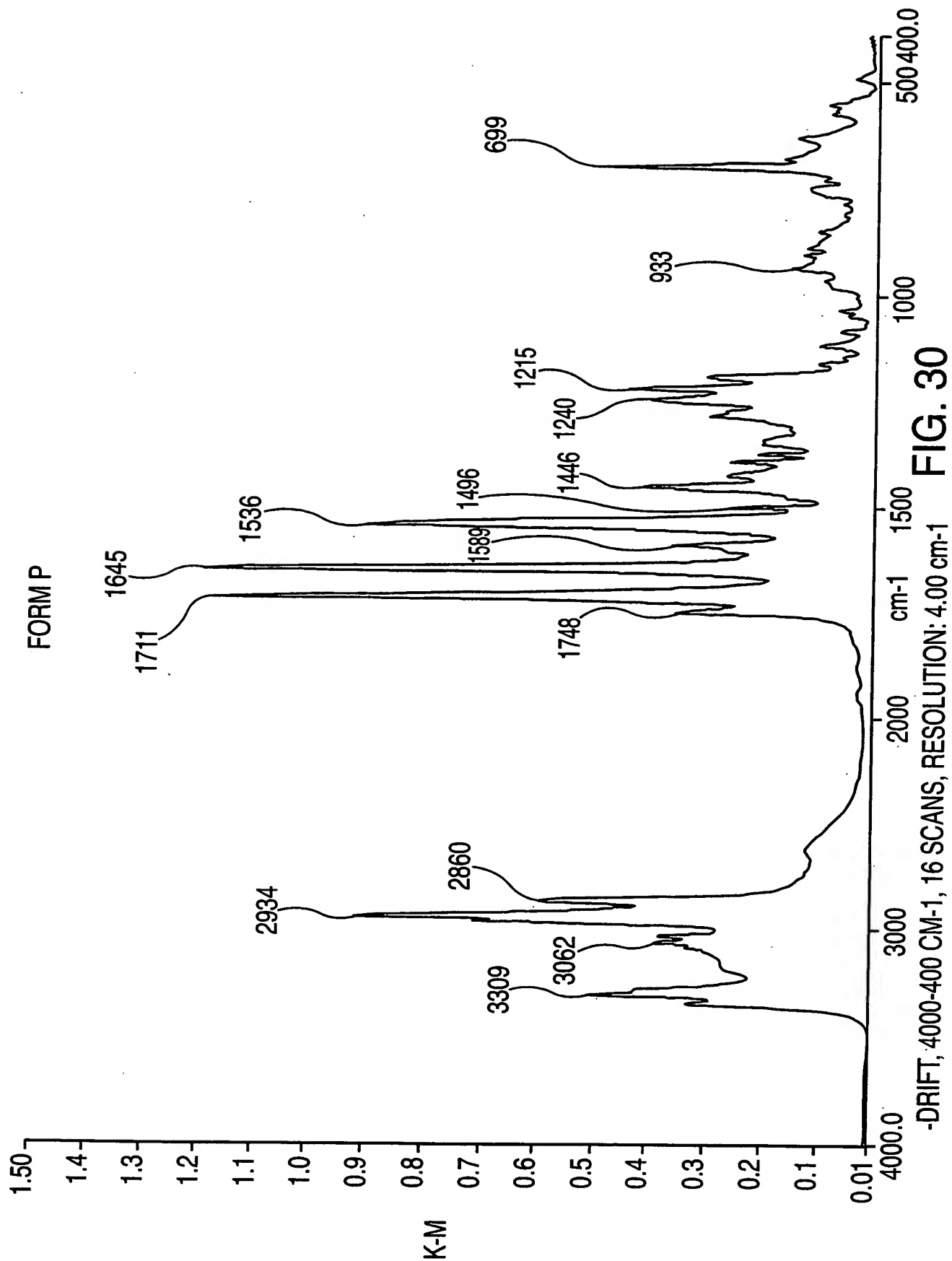


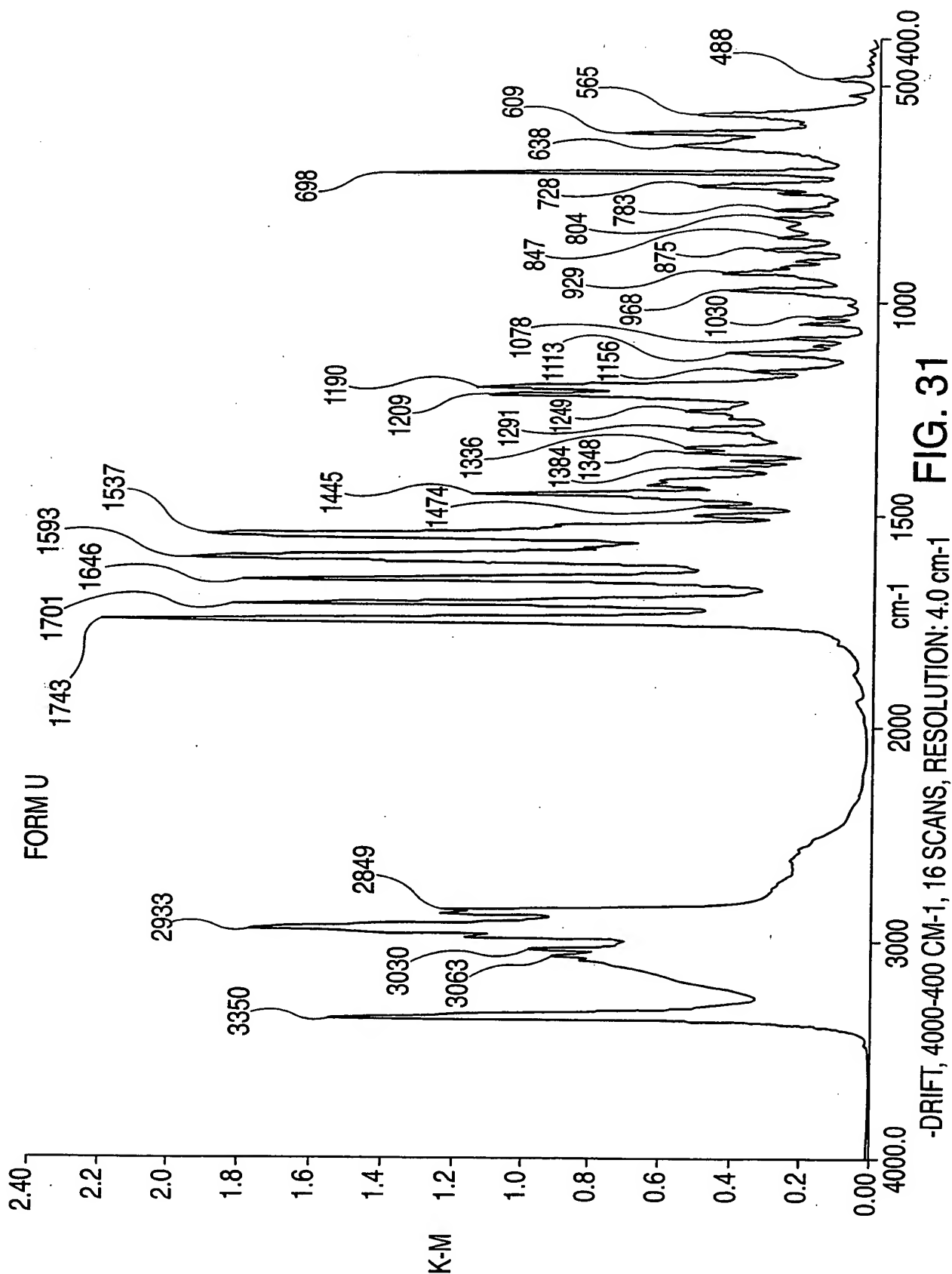
TRANSFORMATION MAY PROCEED THROUGH ANOTHER TERM.
 THERMALLY STABLE AT LOWER HEATING TEMPERATURES (~50°C).
 THERMALLY STABLE FORMS.
 TRANSFORMATION AFTER STORAGE AT ROOM TEMPERATURE.
 MIXTURE WITH STARTING FORM.
 WHEN STARTING MATERIAL CONTAINS SEEDS.
 RESULTS MIGHT VARY DEPENDING ON THE SOLVATE OF FORM EPSILON USED.

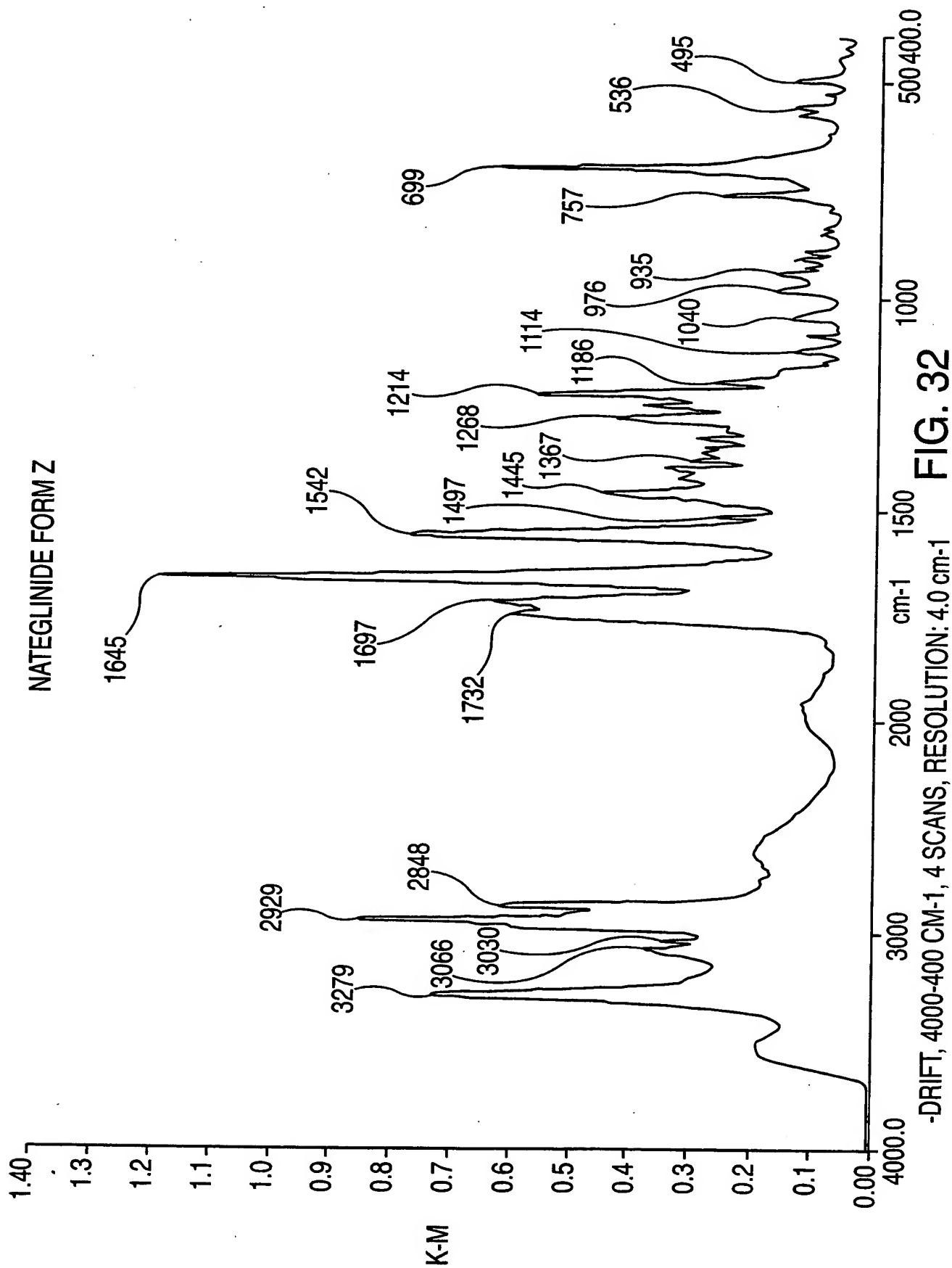
Thermal Stability Chart

FIG. 28









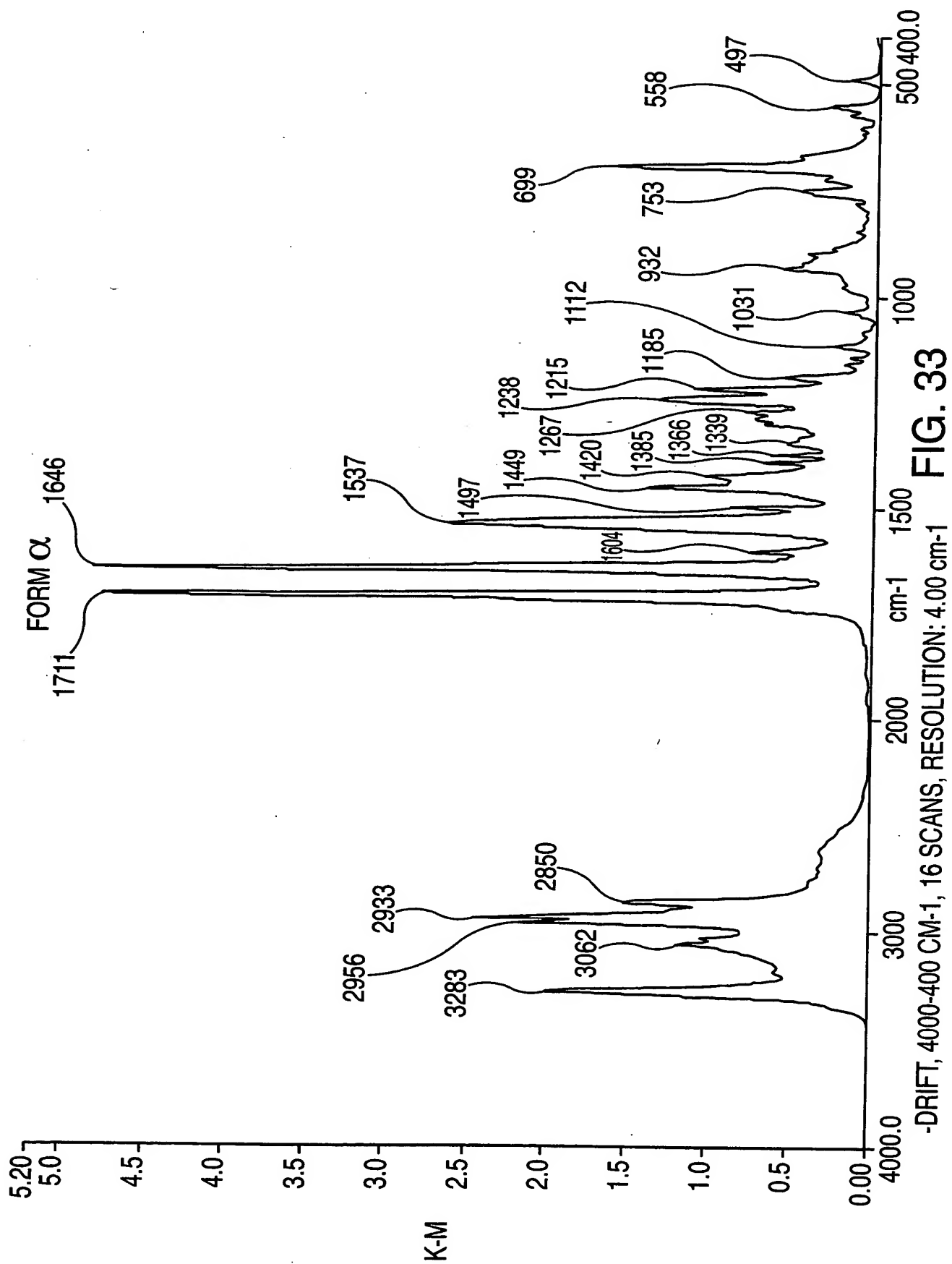
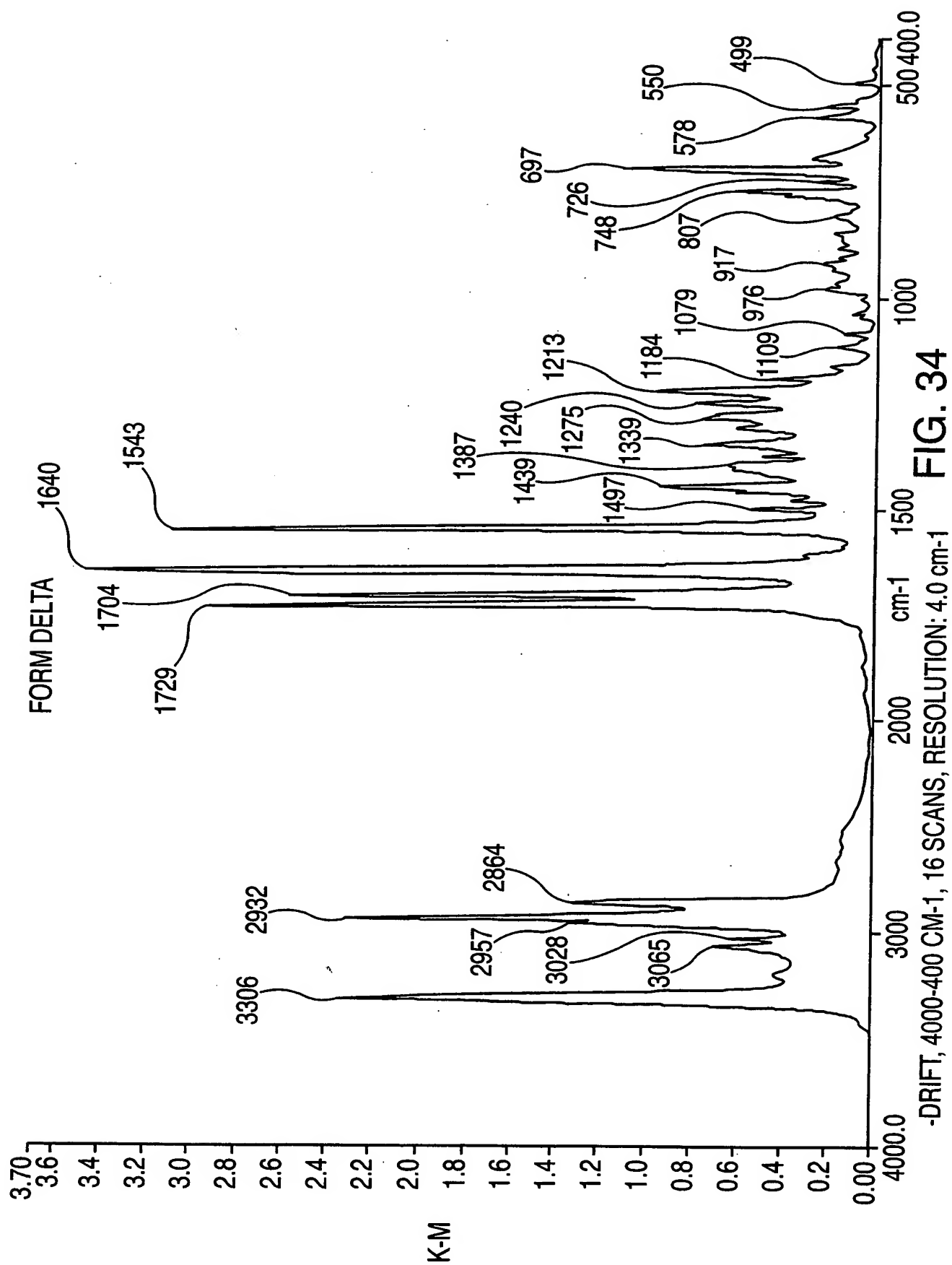
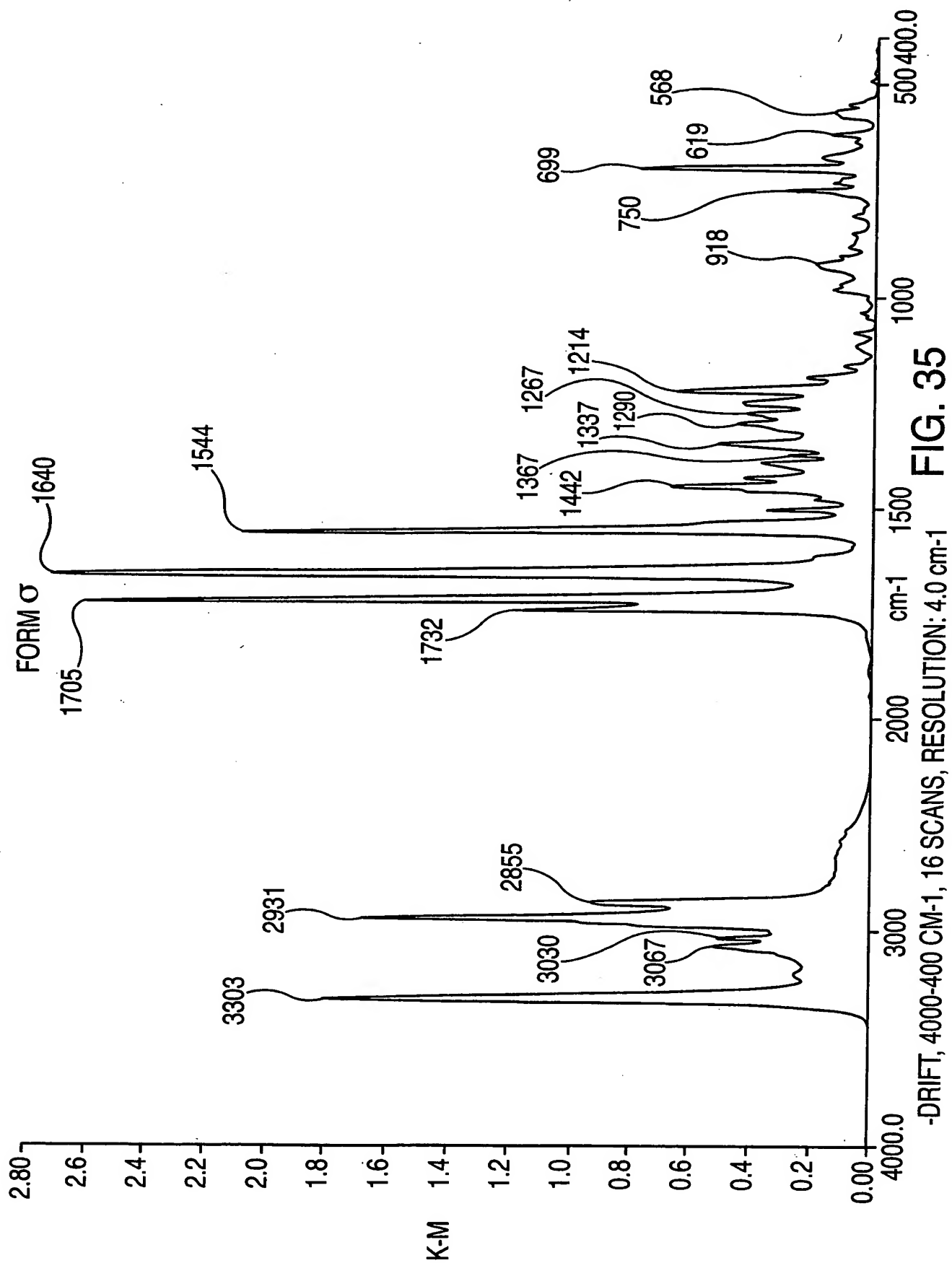
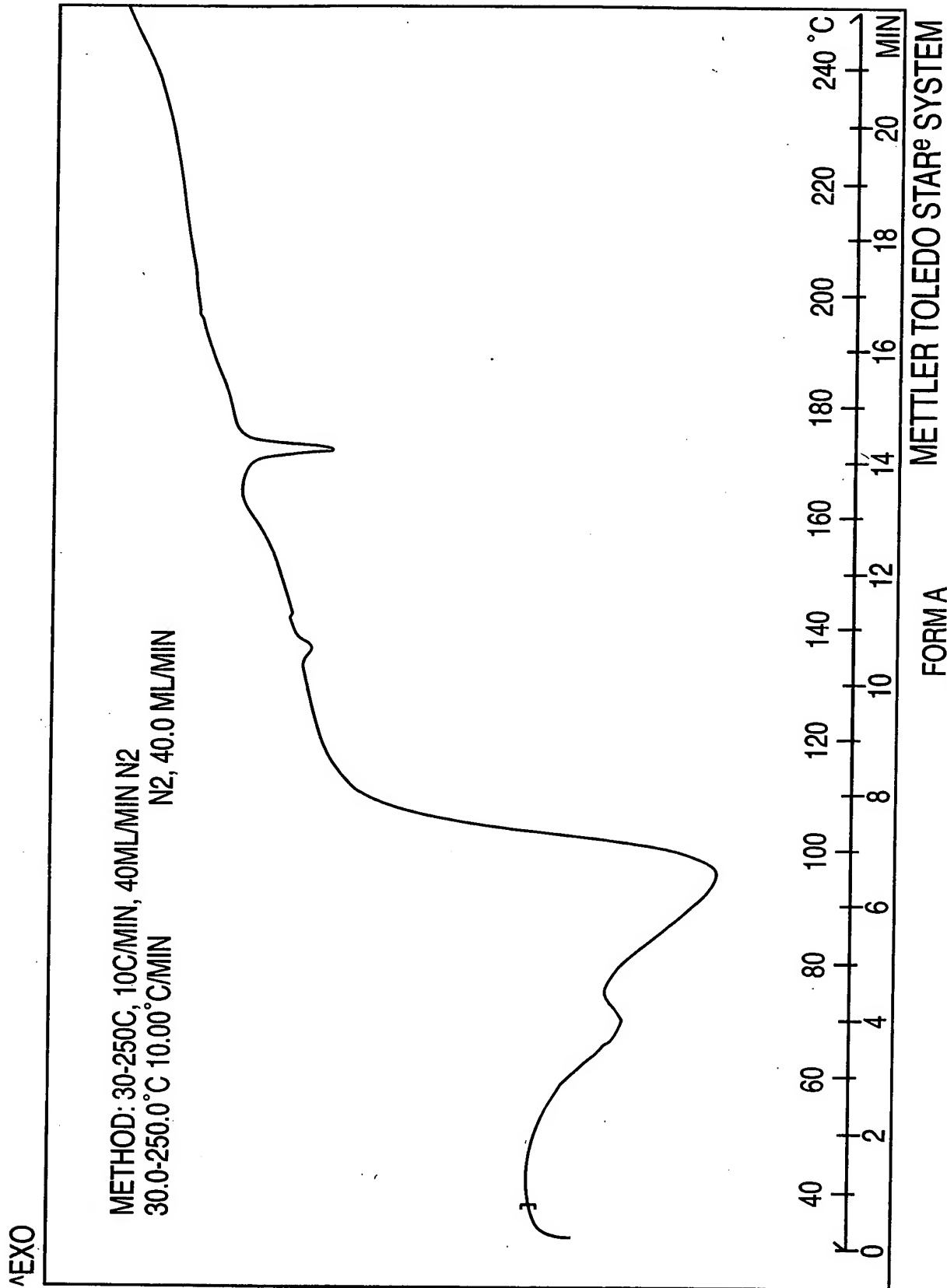


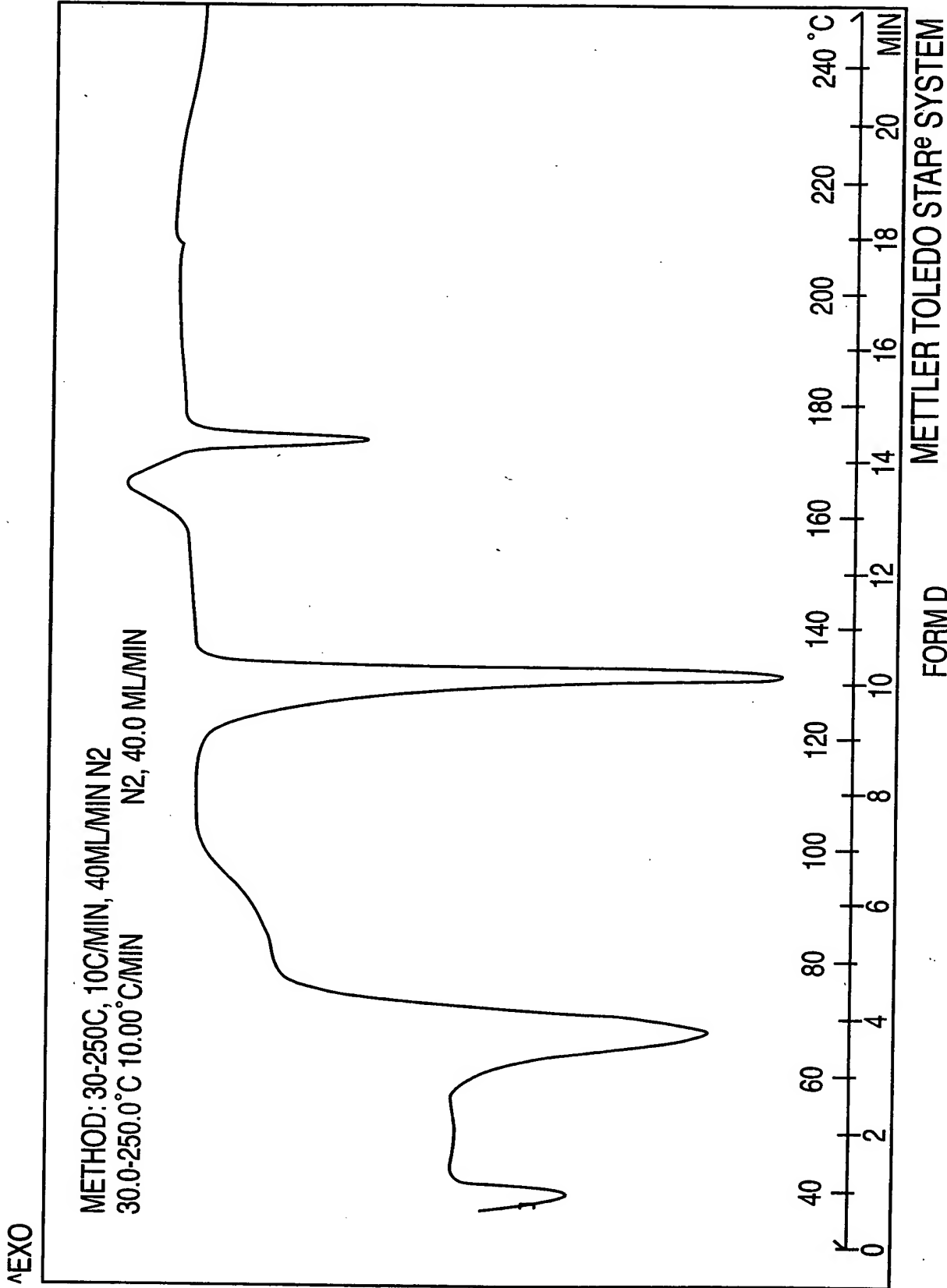
FIG. 33

-DRIFT, 4000-400 CM-1, 16 SCANS, RESOLUTION: 4.00 CM-1



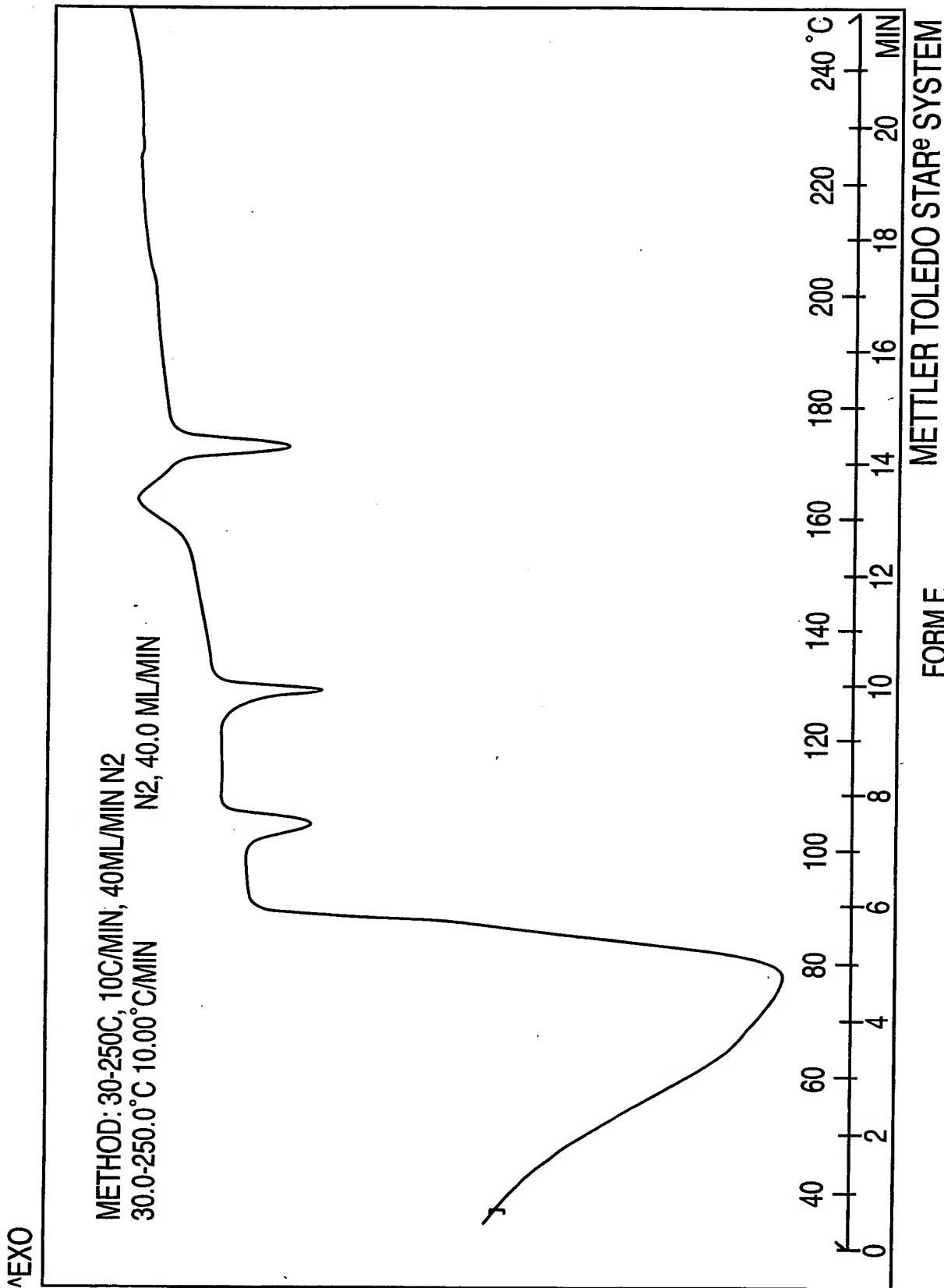






FORM D

FIG. 37



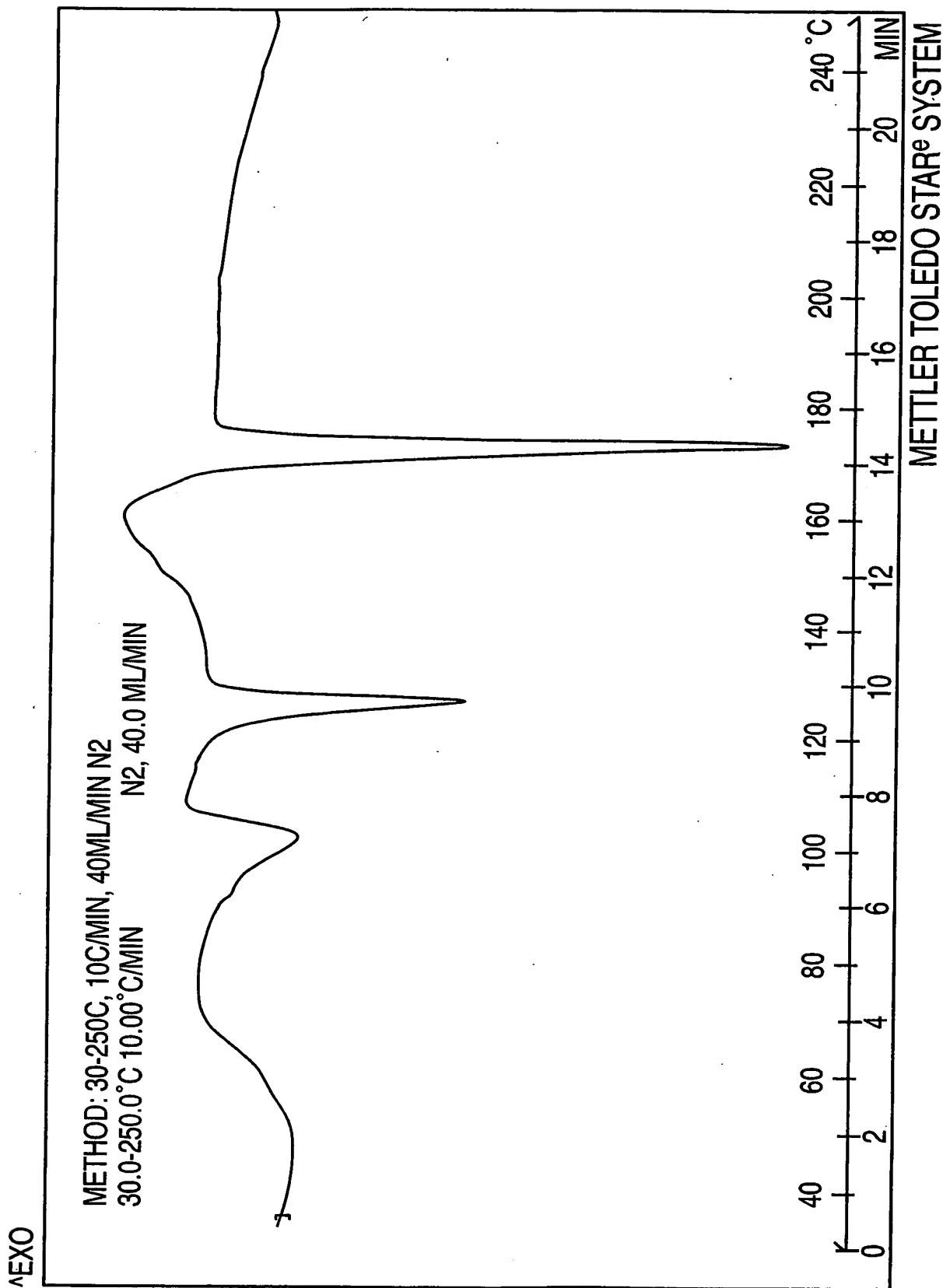


FIG. 39

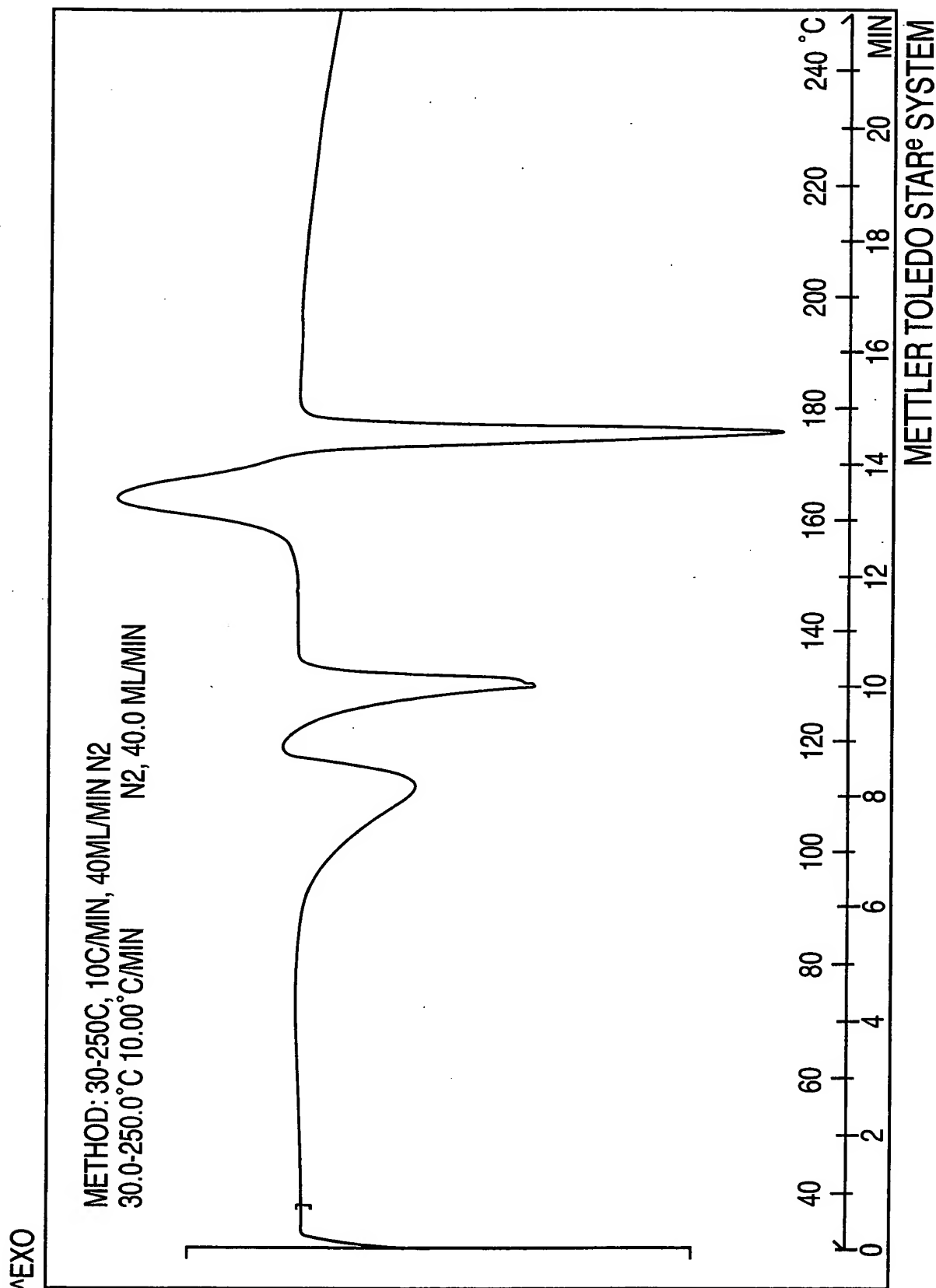


FIG. 40

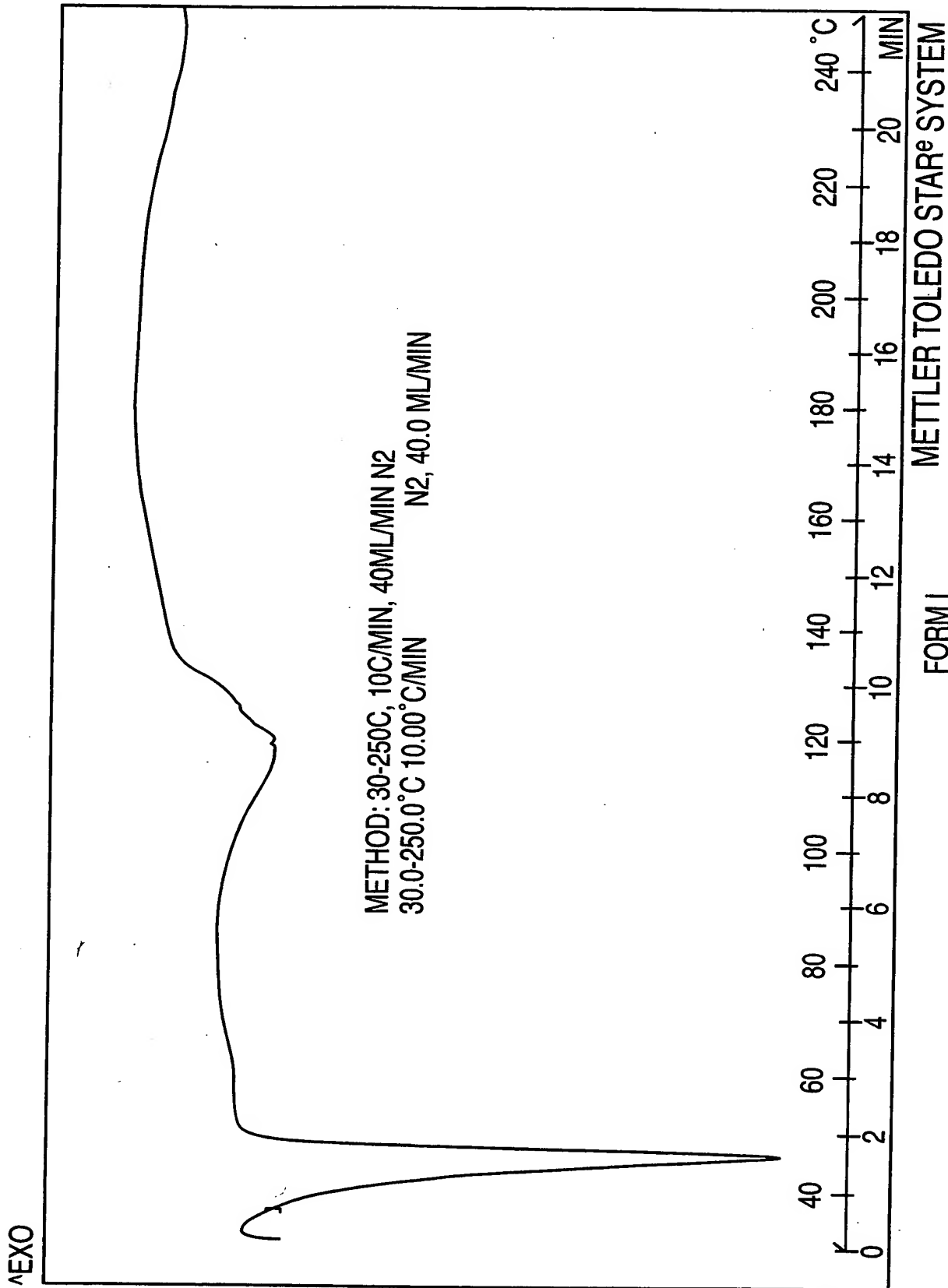


FIG. 41

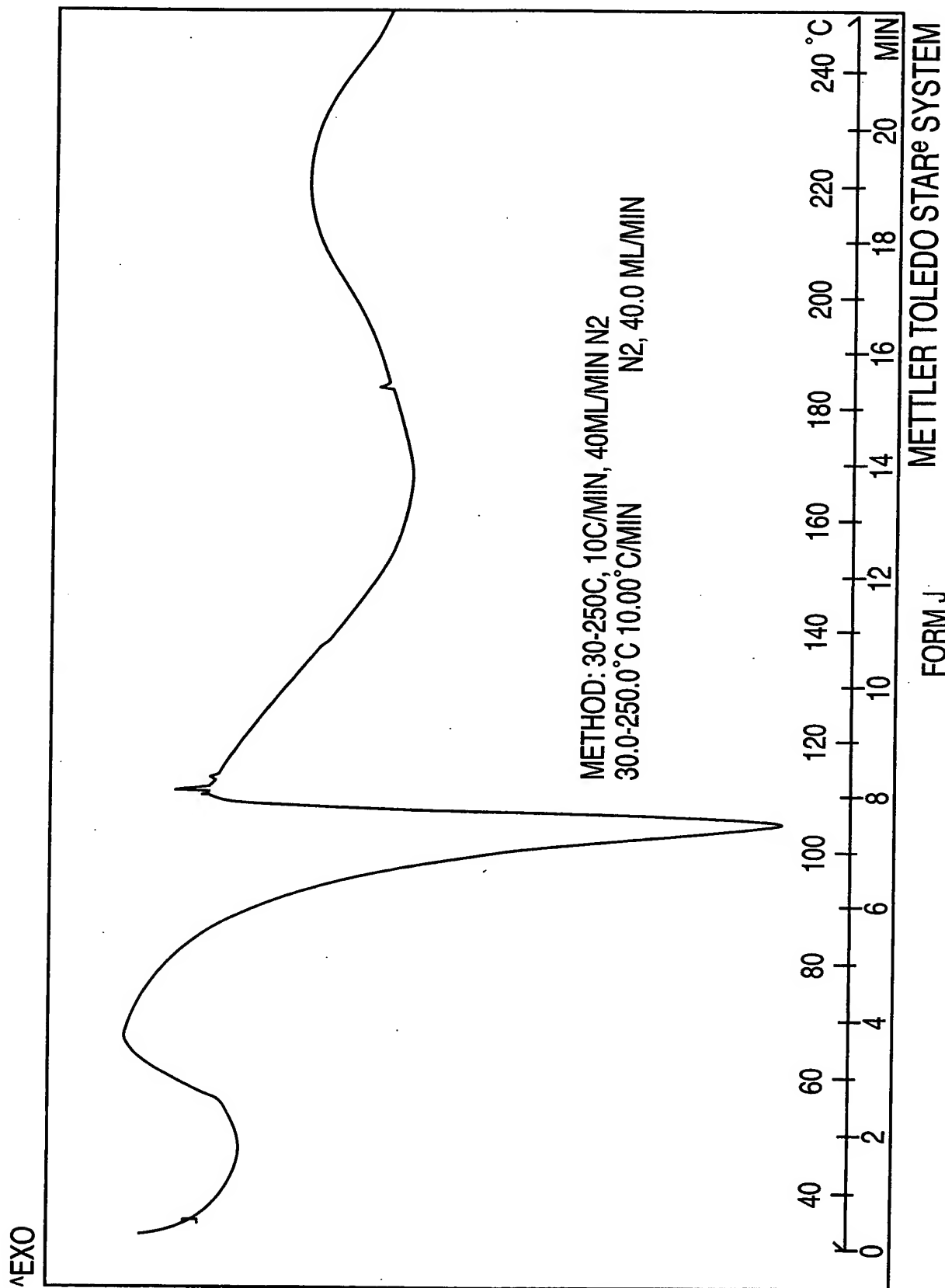


FIG. 42

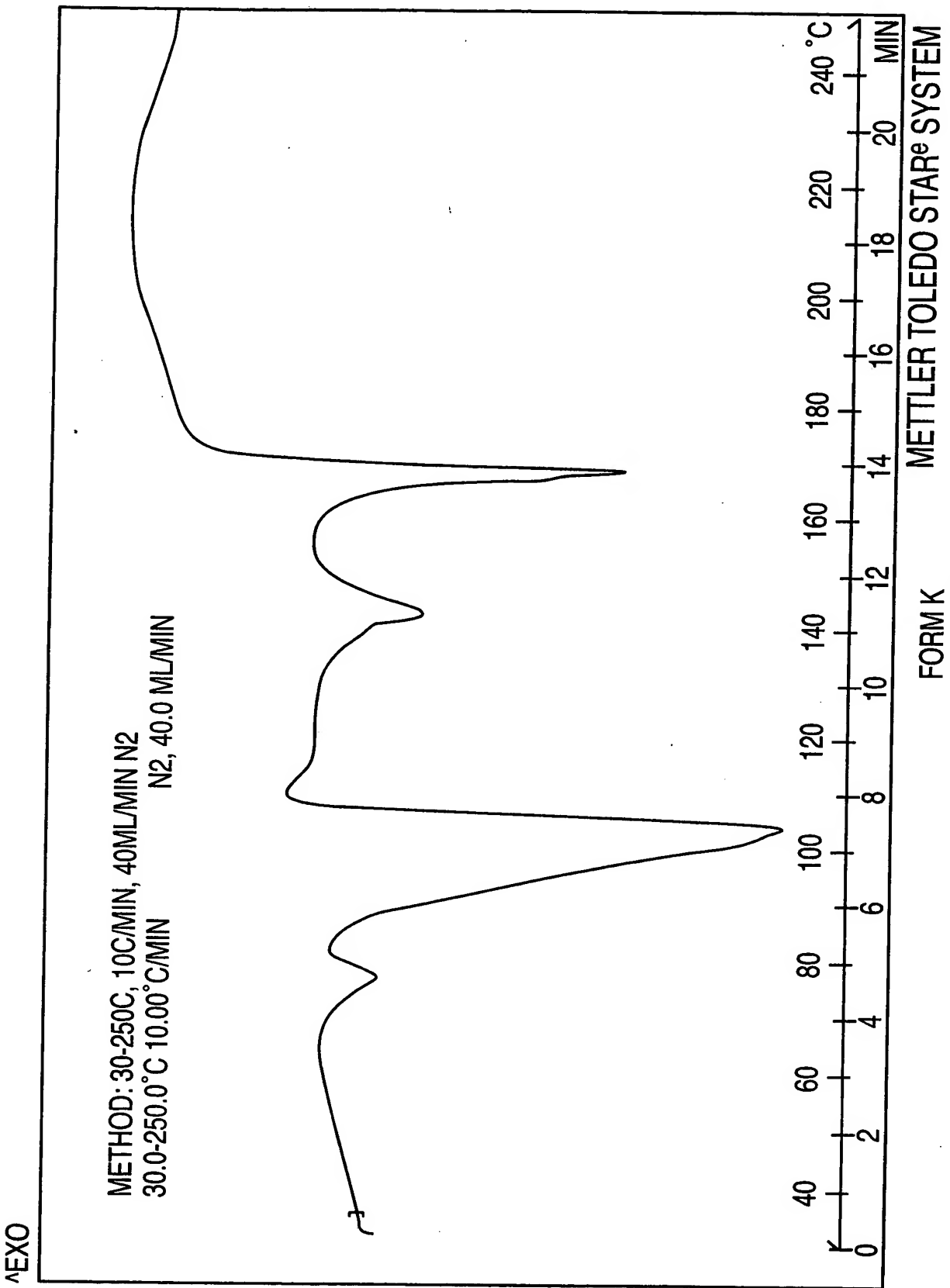


FIG. 43

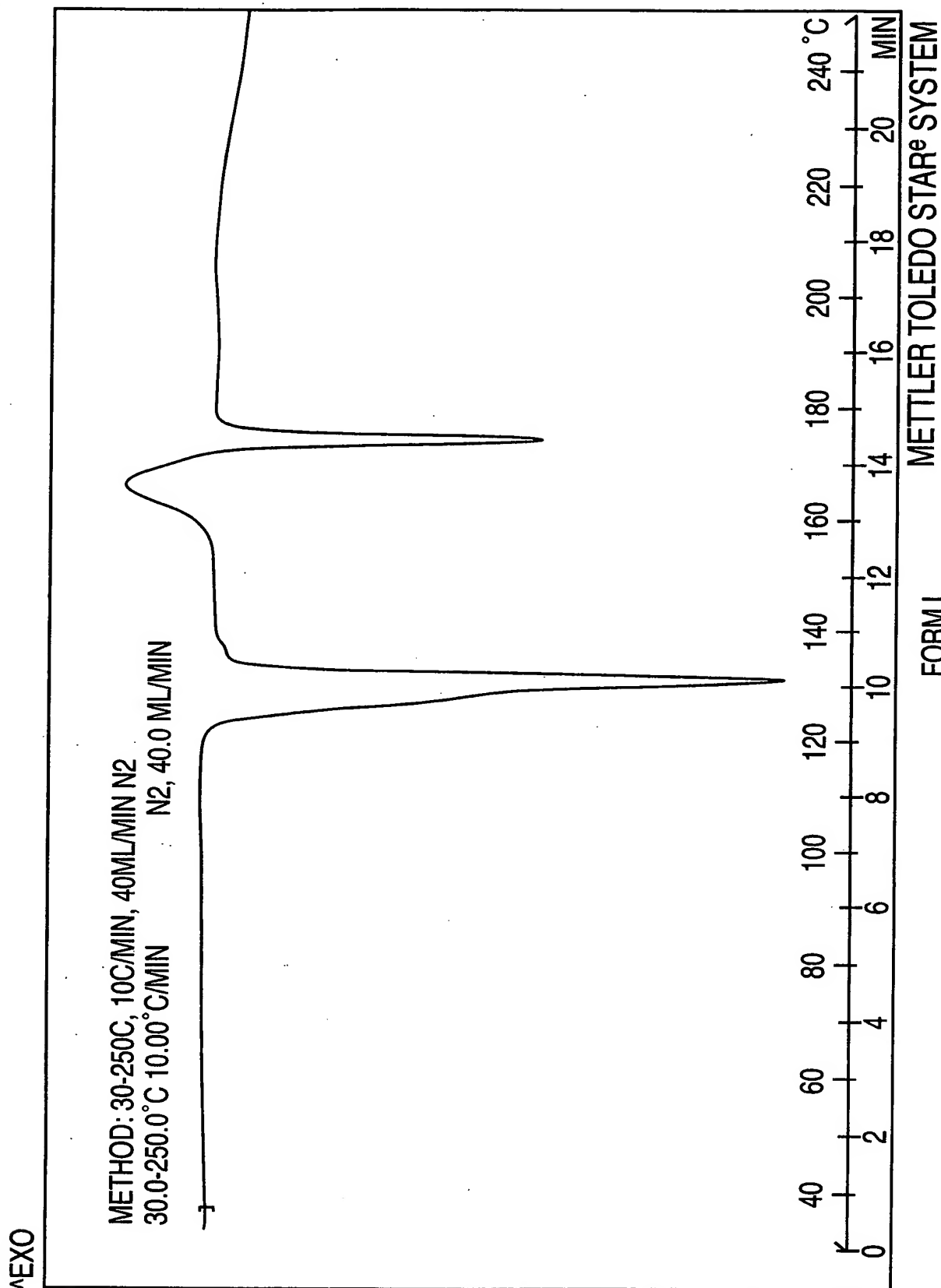
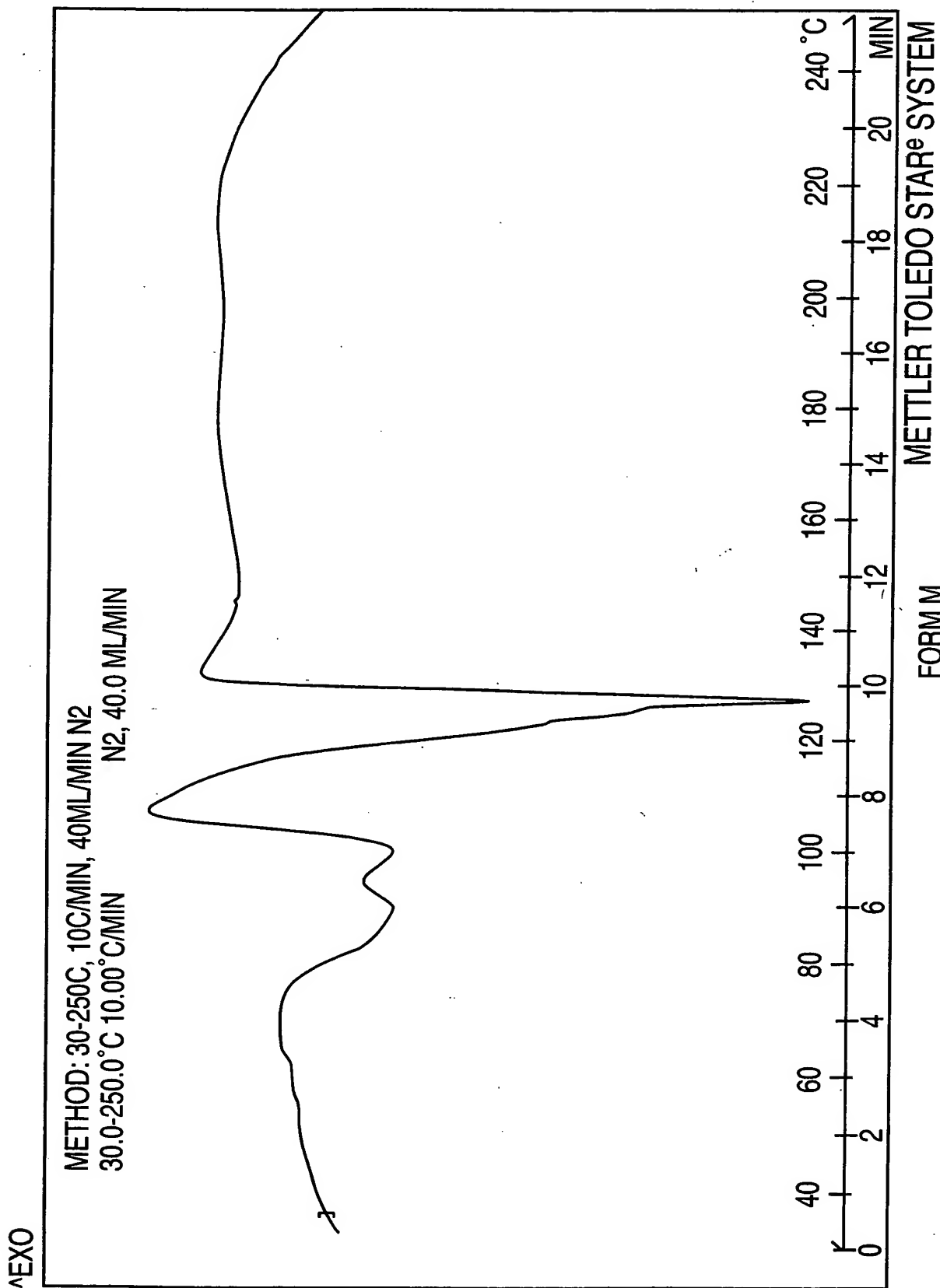


FIG. 44



FORM M

FIG. 45

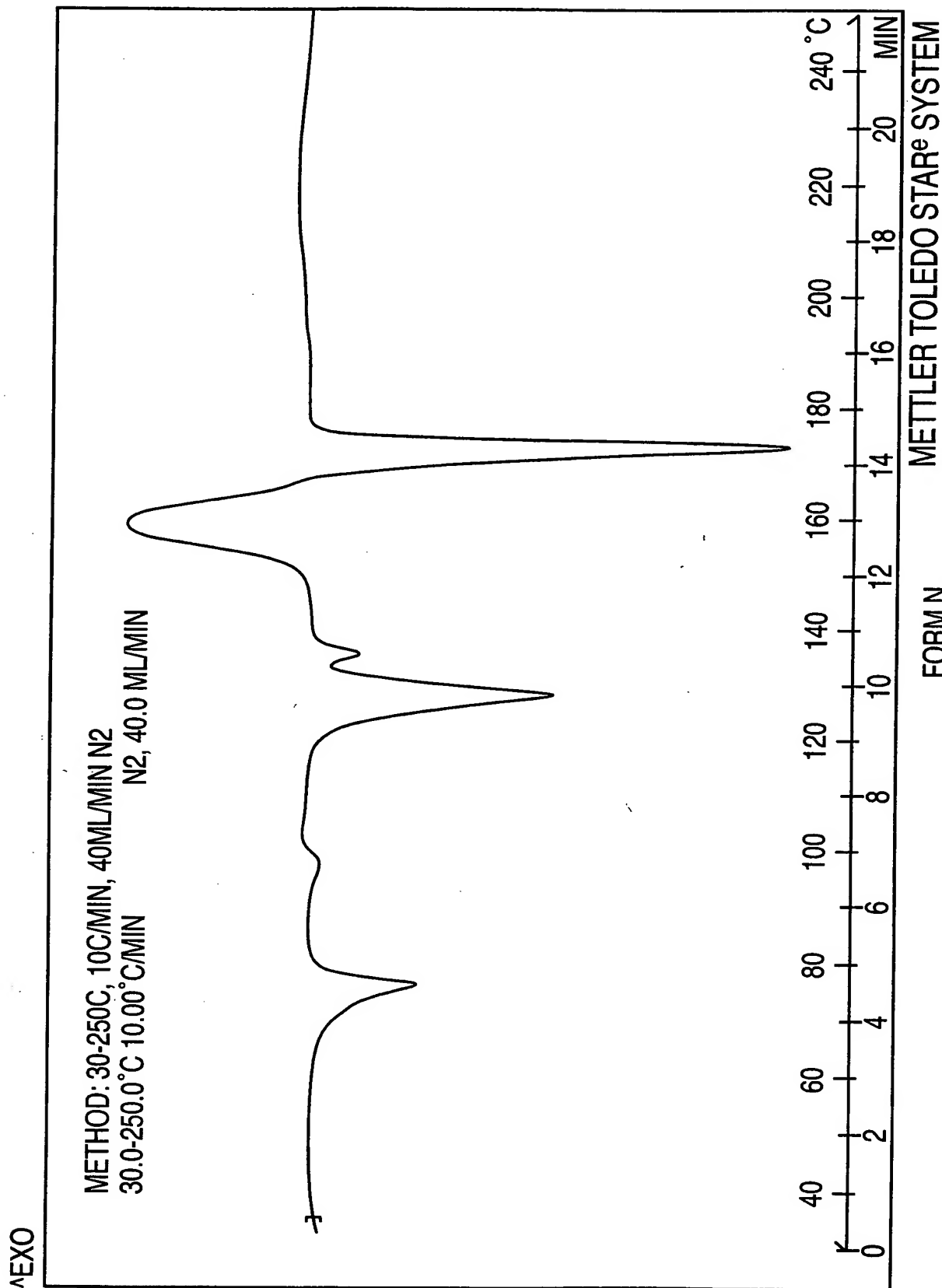


FIG. 46

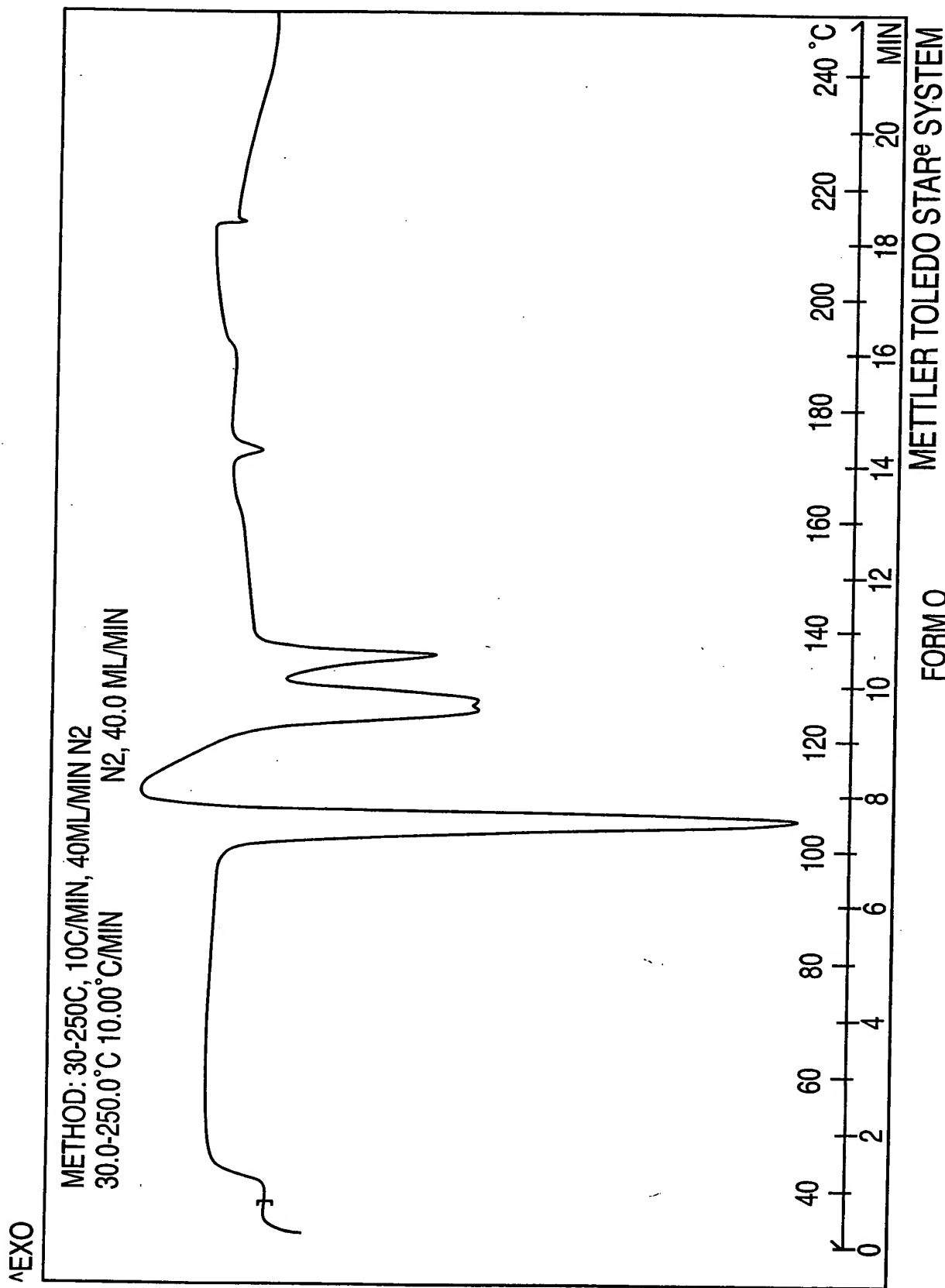


FIG. 47

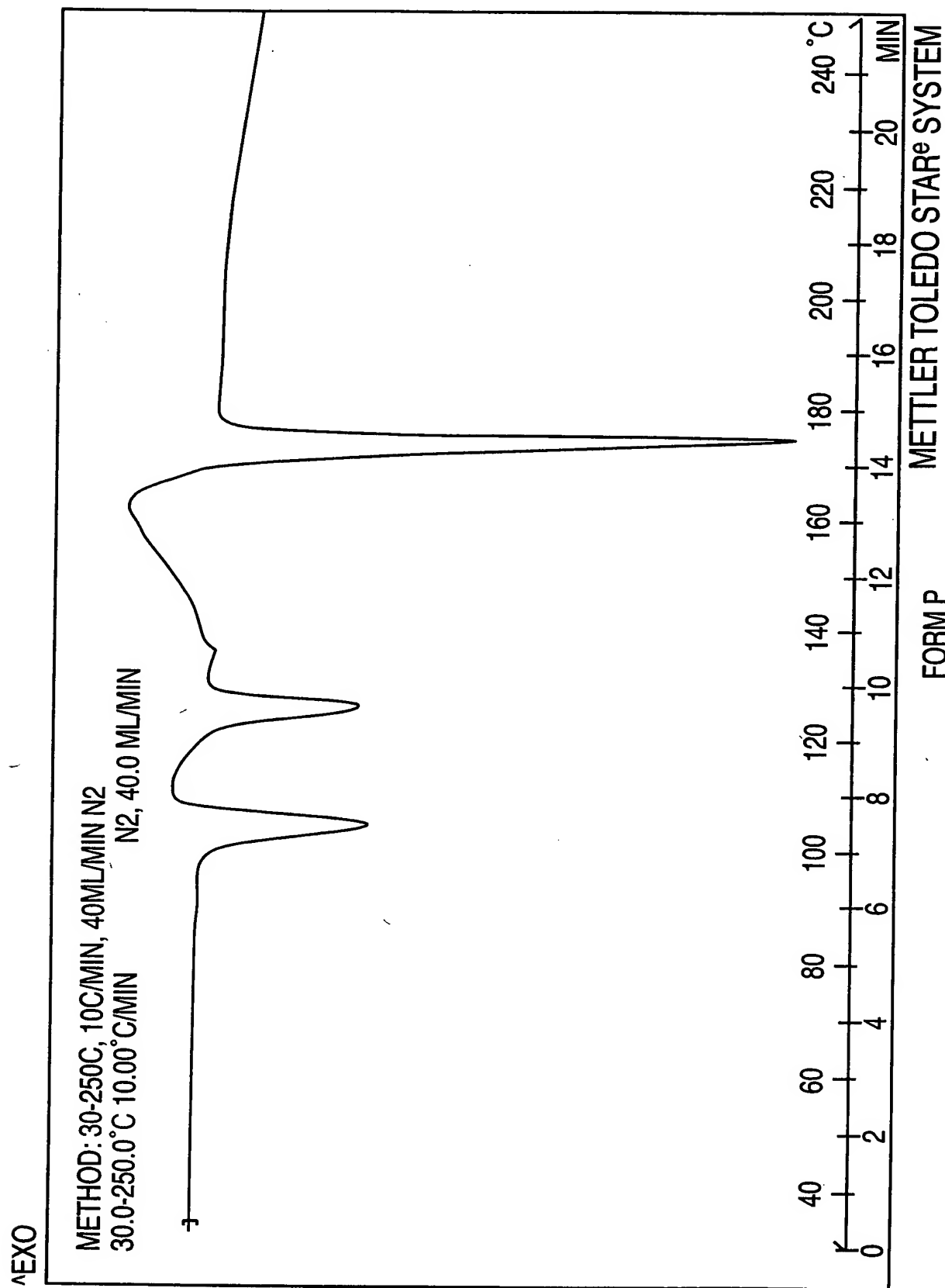


FIG. 48

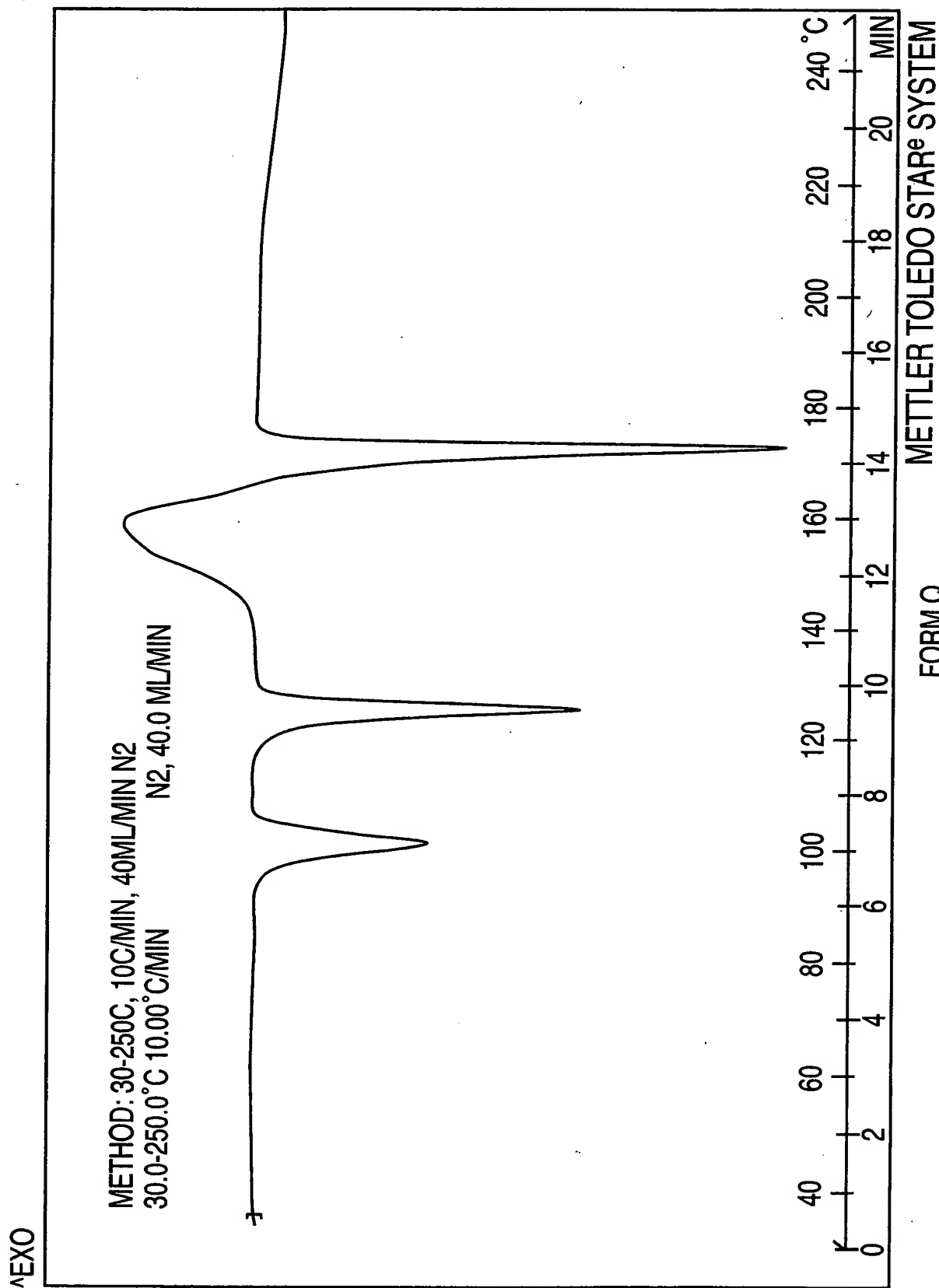


FIG. 49

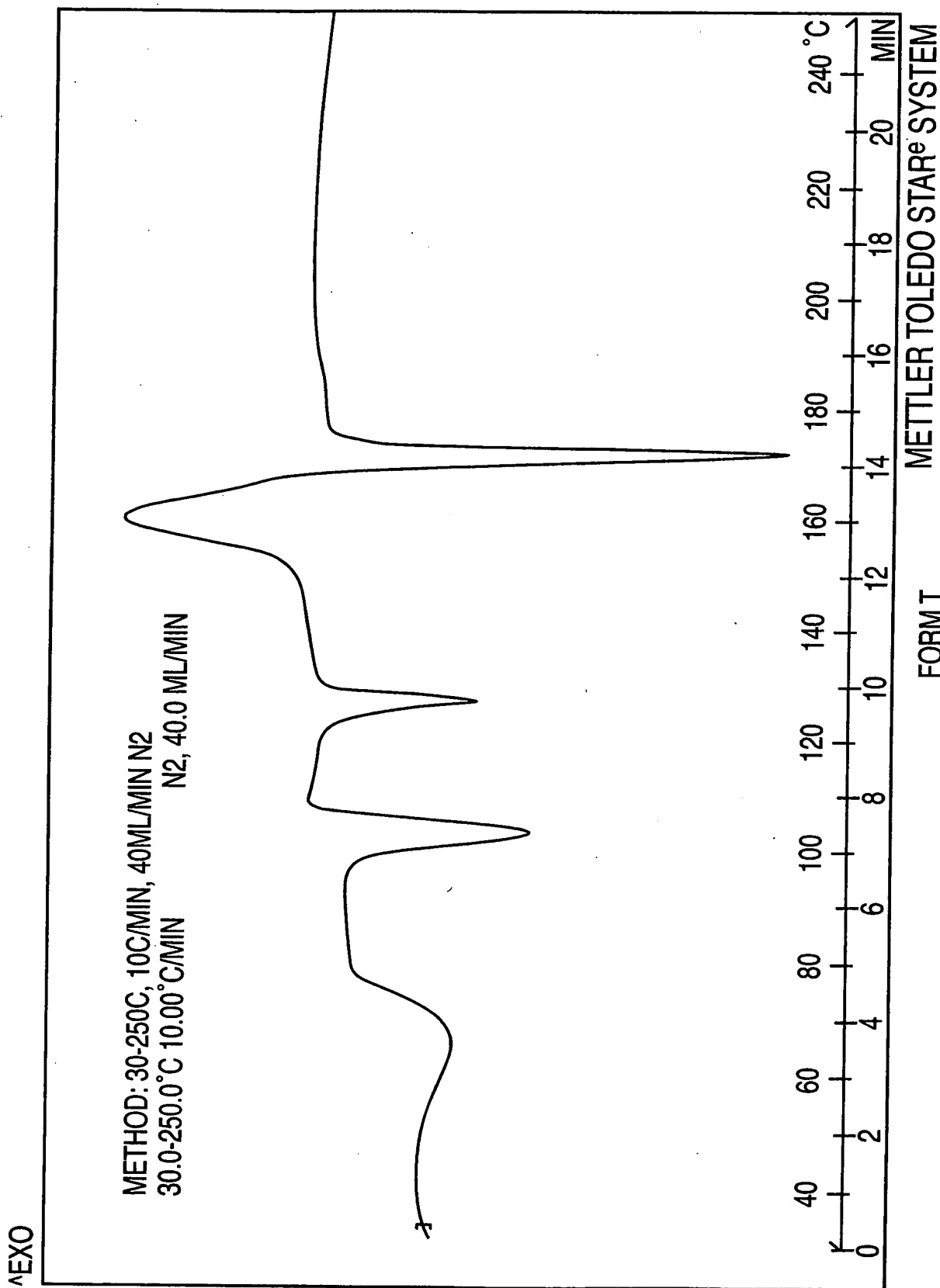
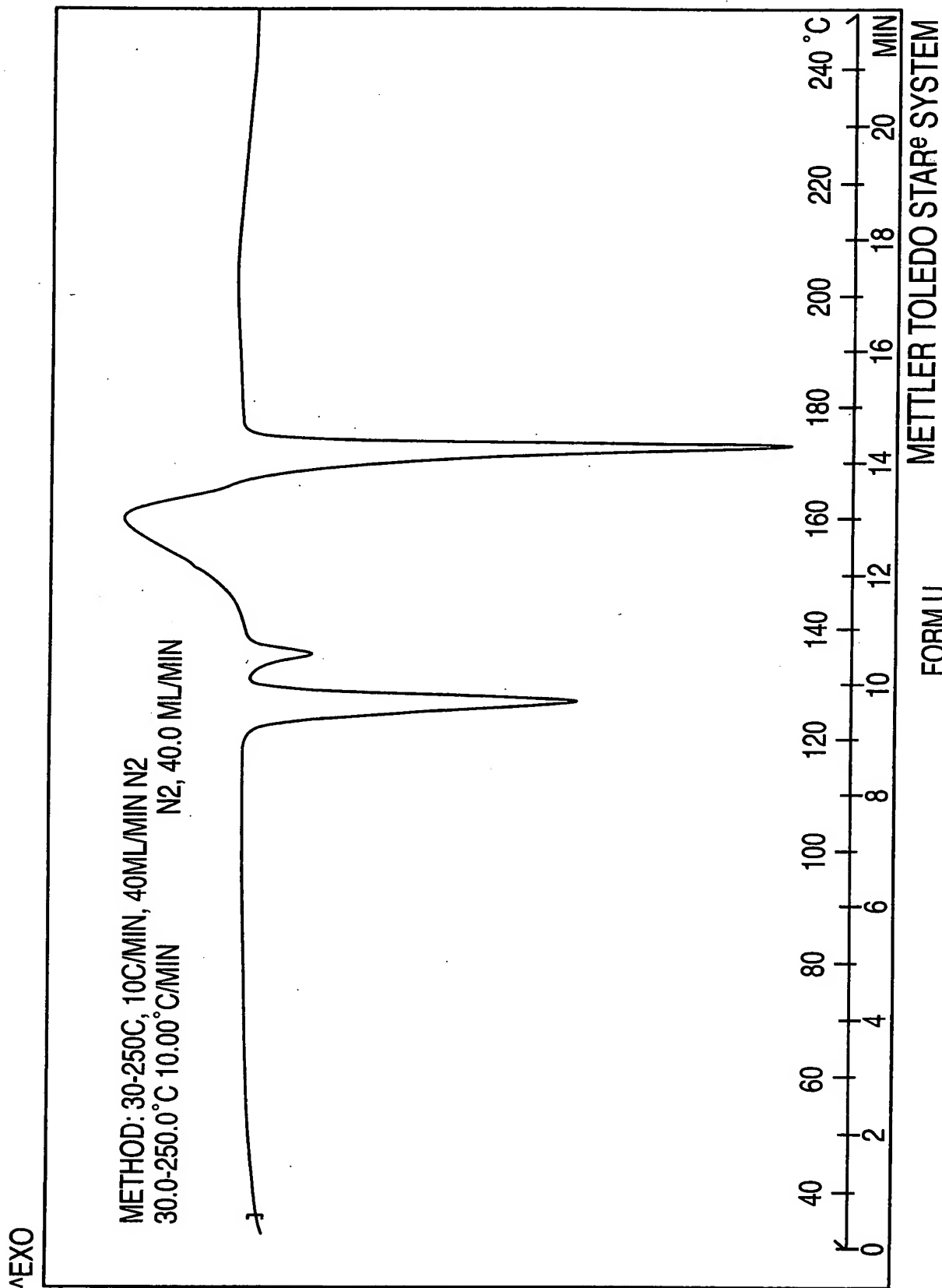


FIG. 50



FORM U
FIG. 51

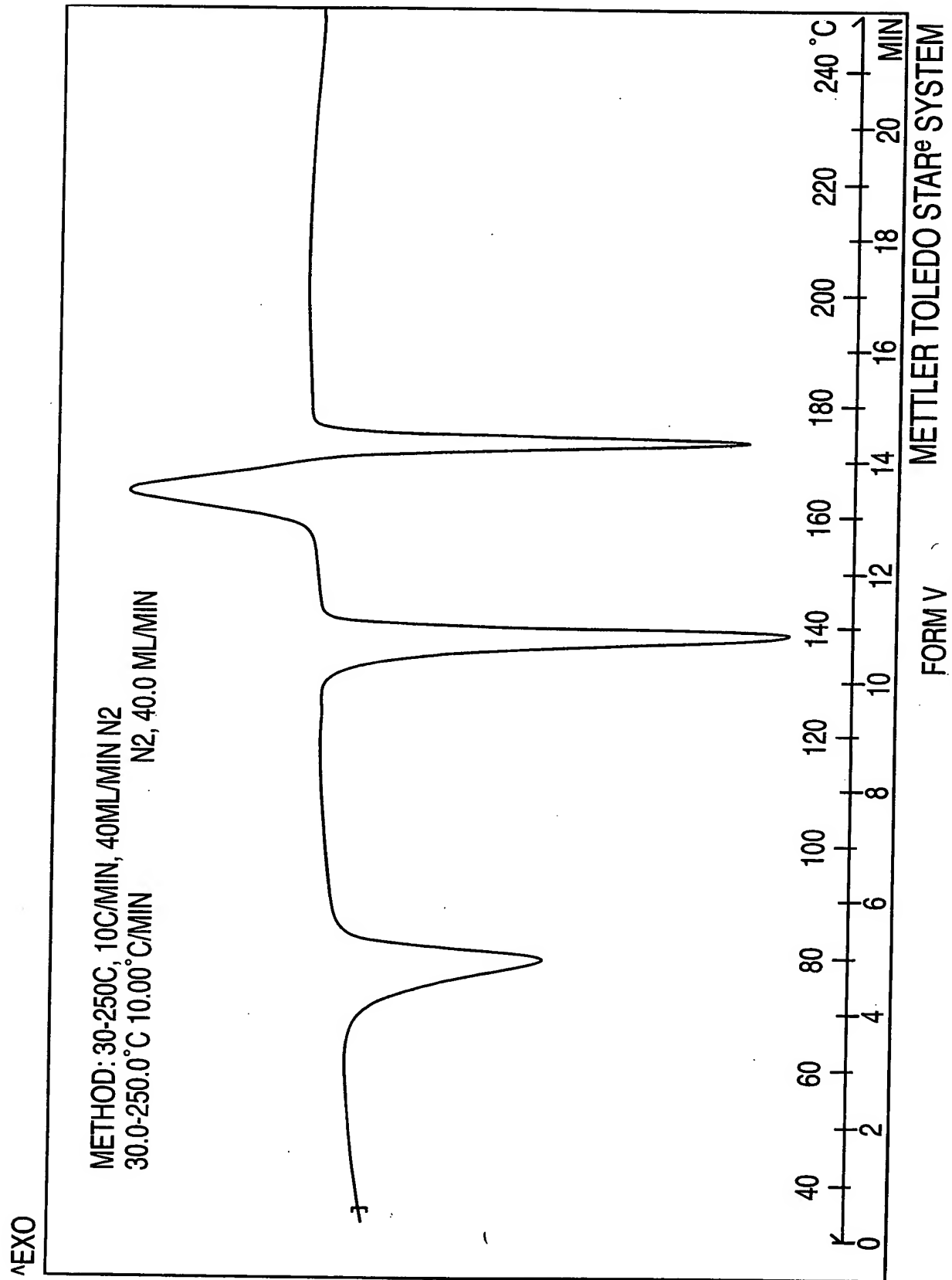


FIG. 52

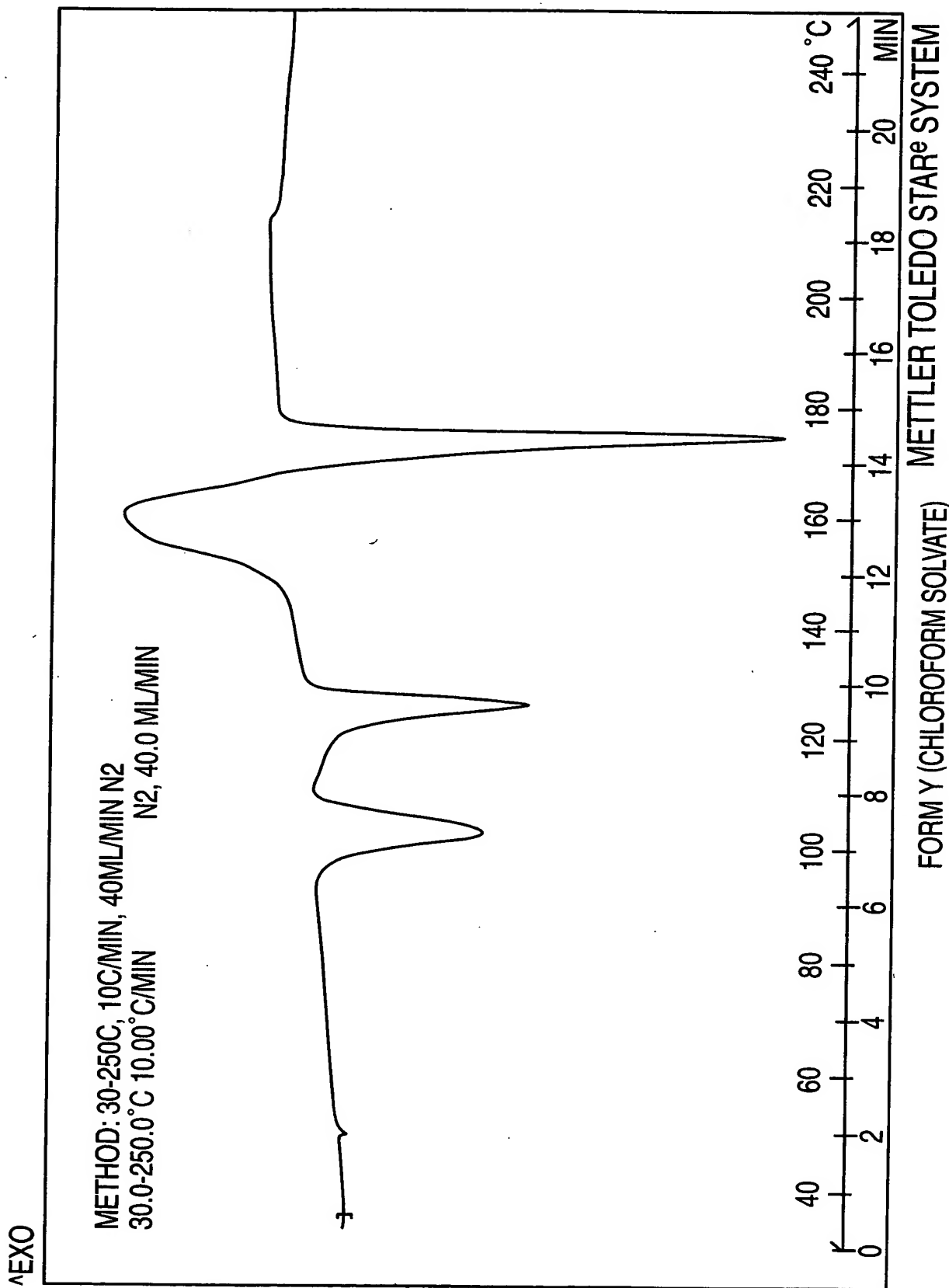
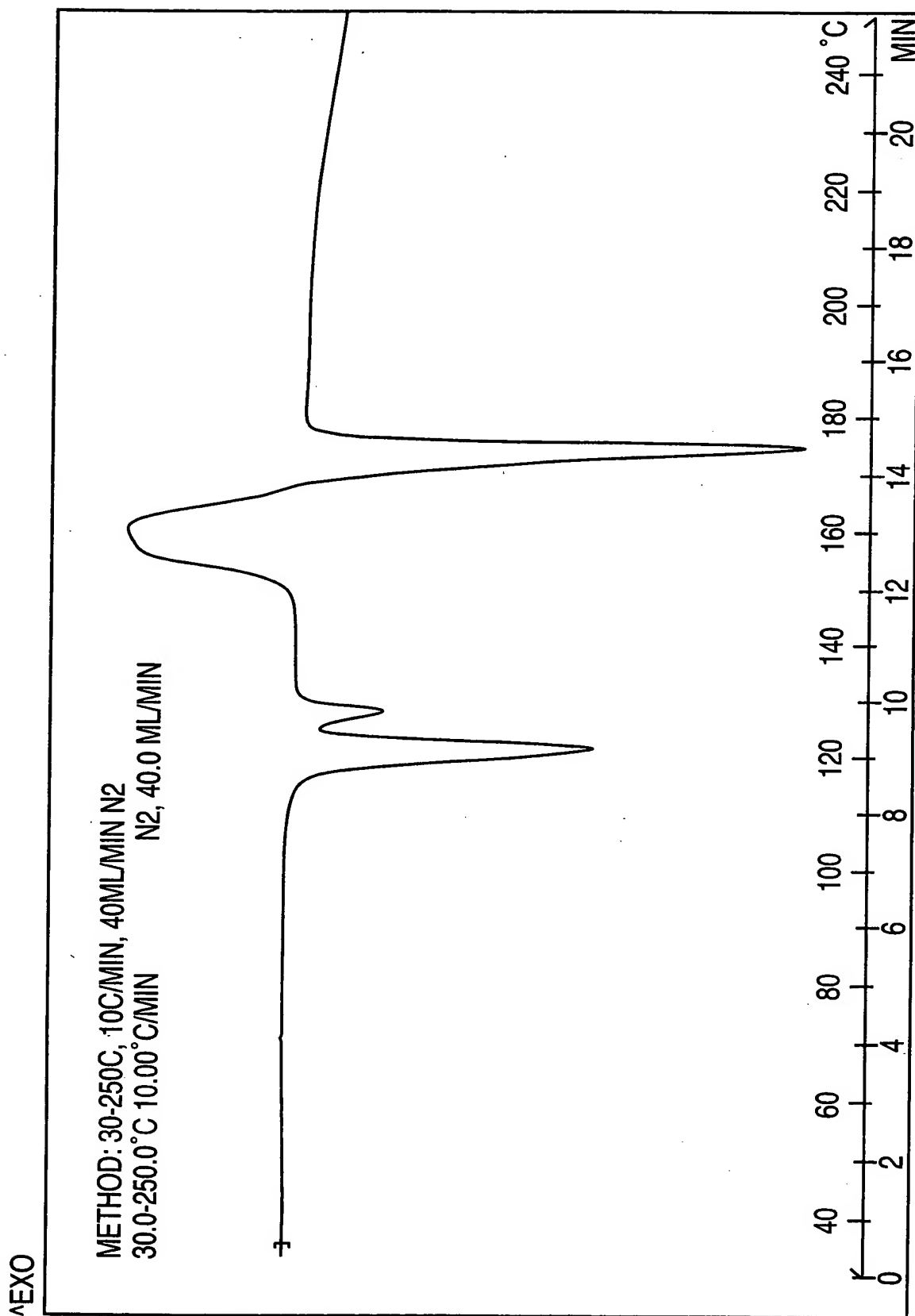
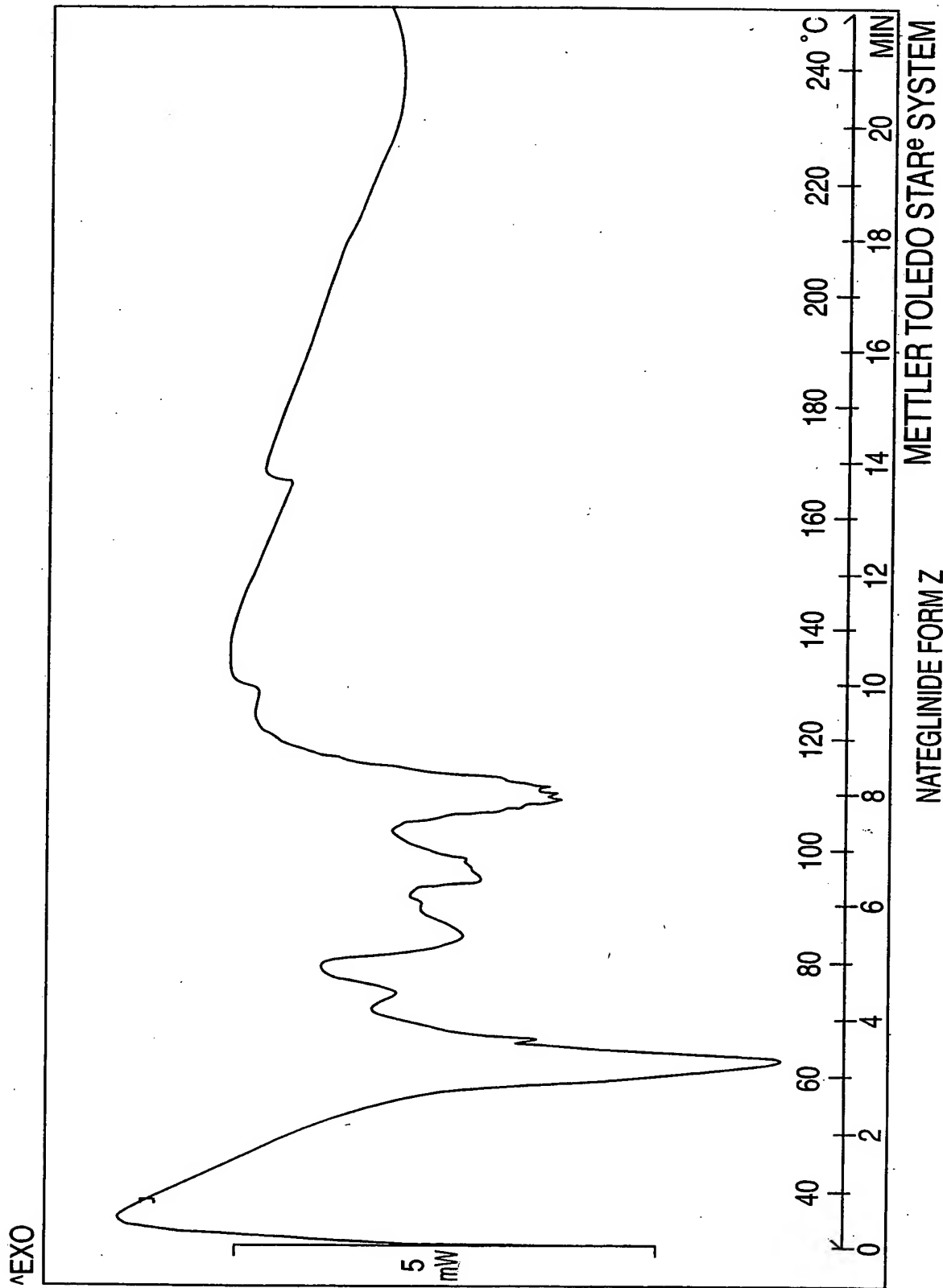


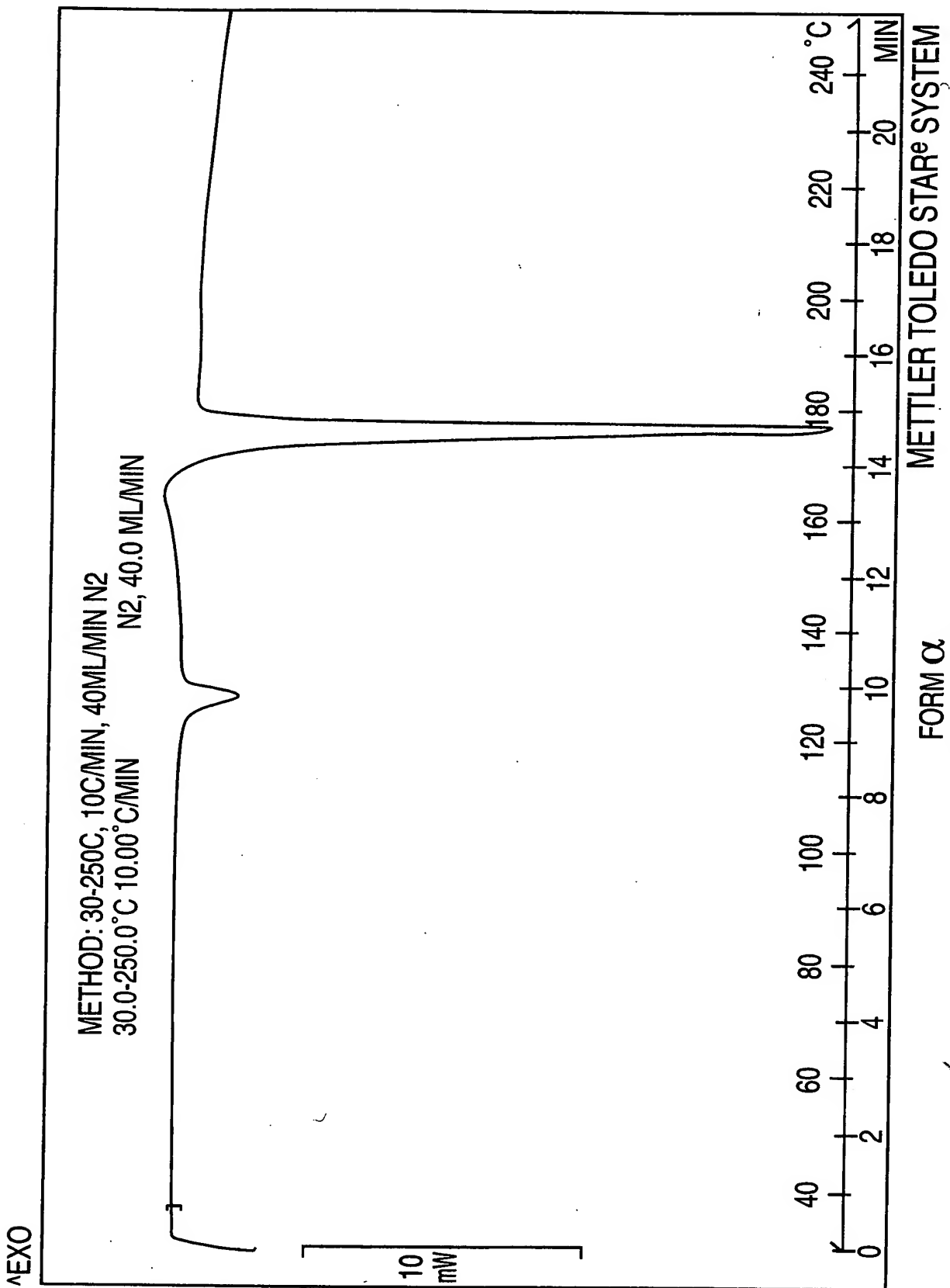
FIG. 53



FORM Y (DICHLOROMETHENE SOLVATE) METTLER TOLEDO STAR^e SYSTEM

FIG. 54





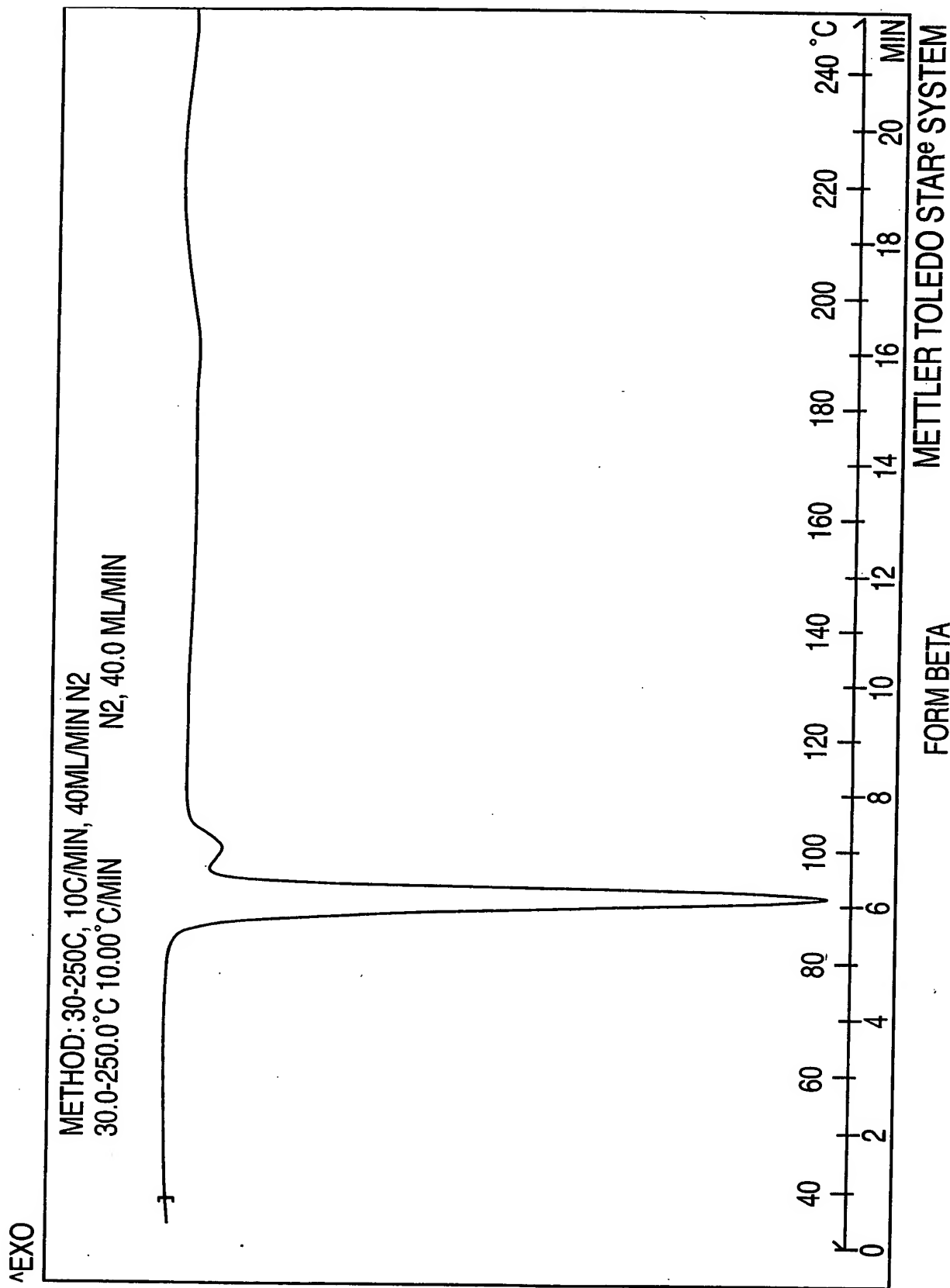


FIG. 57

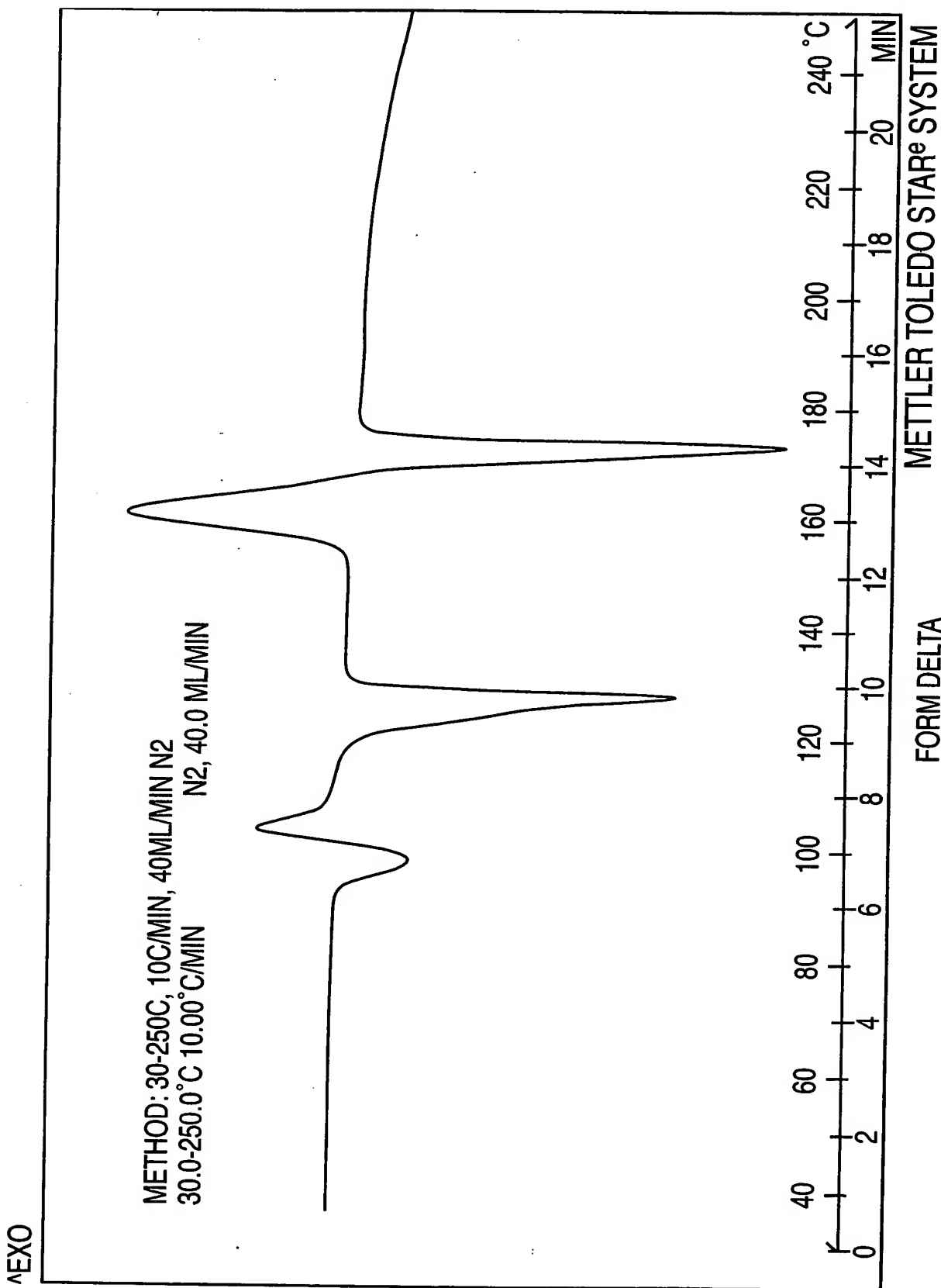
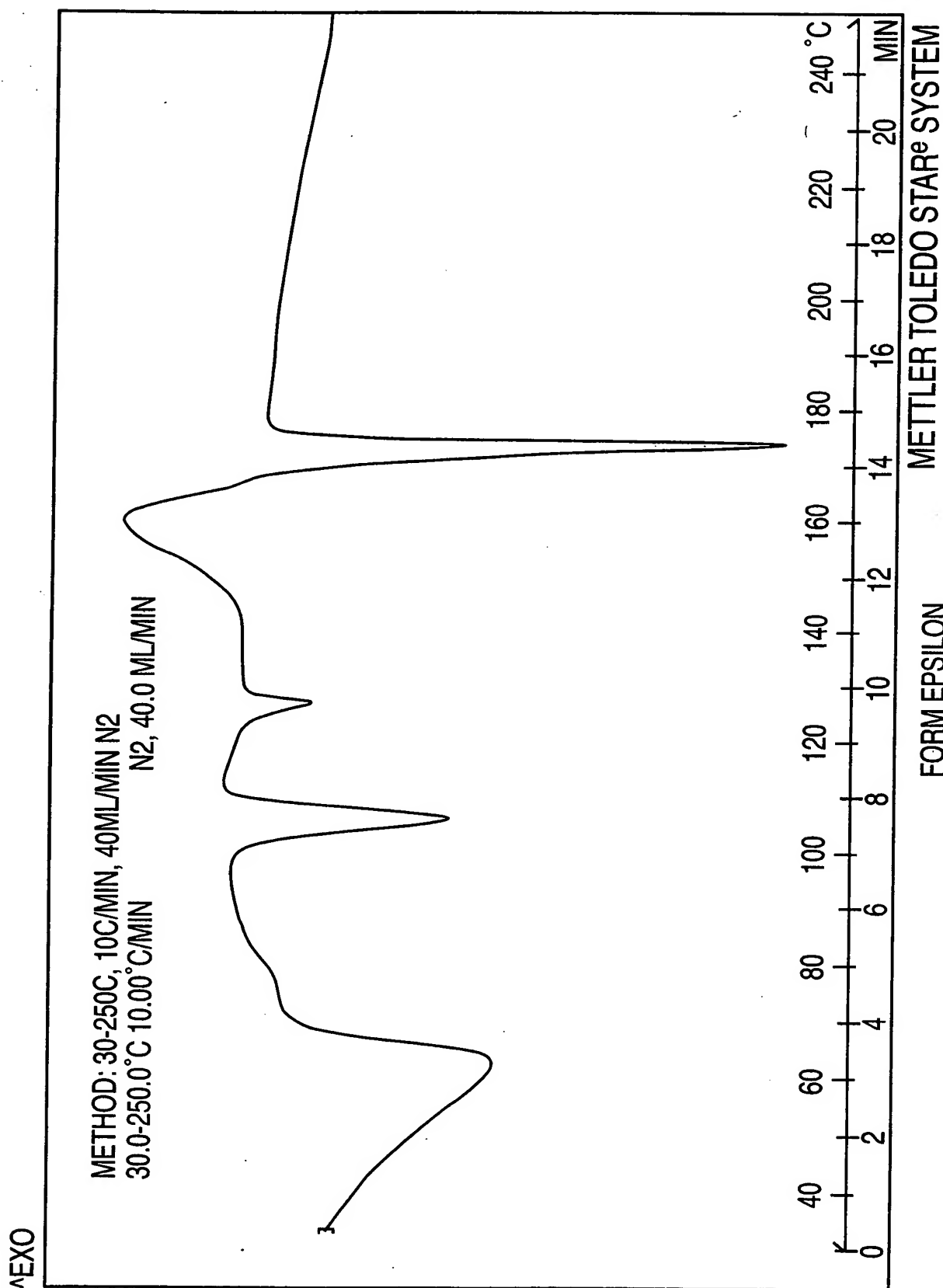
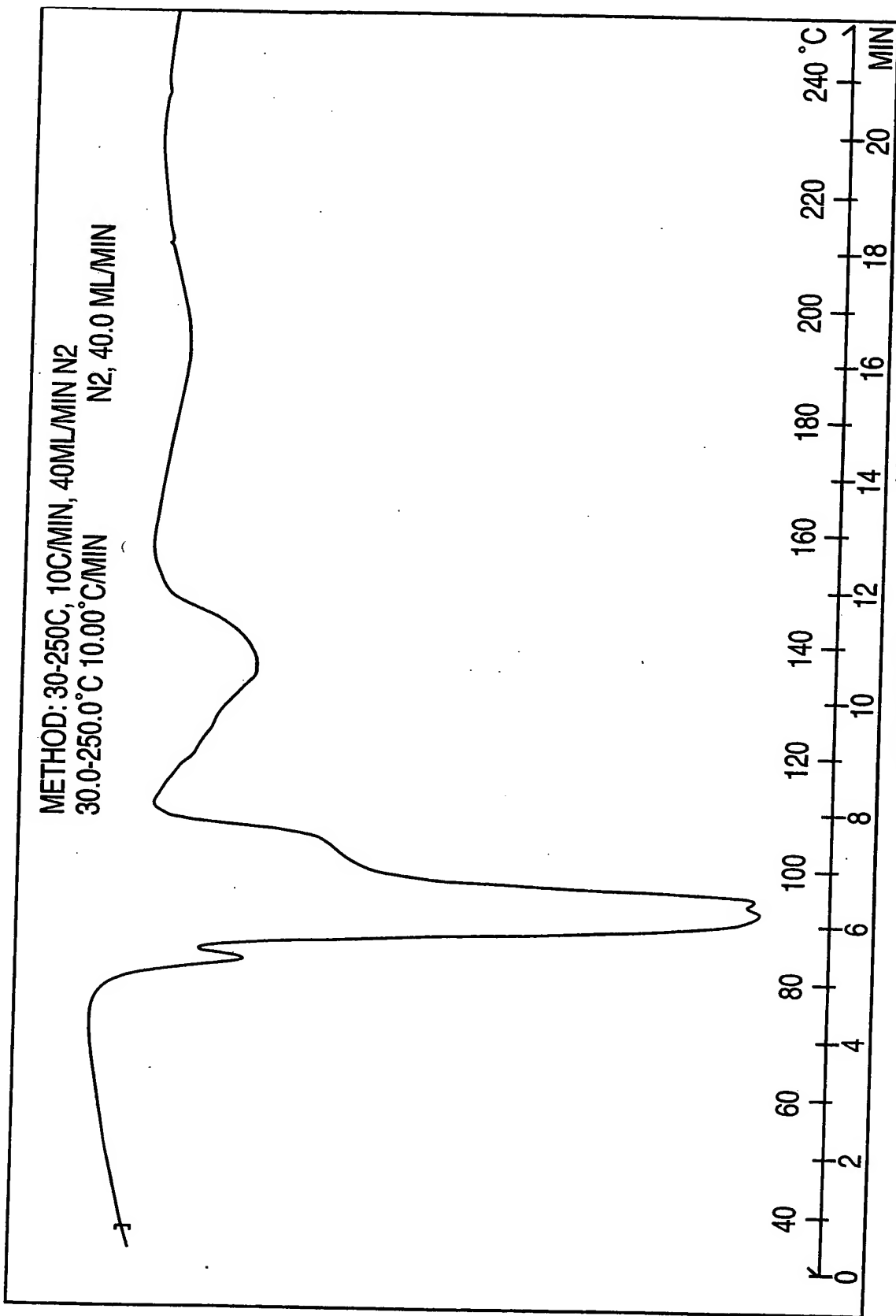


FIG. 58



^EXO



FORM GAMMA
METTLER TOLEDO STARE SYSTEM

FIG. 60

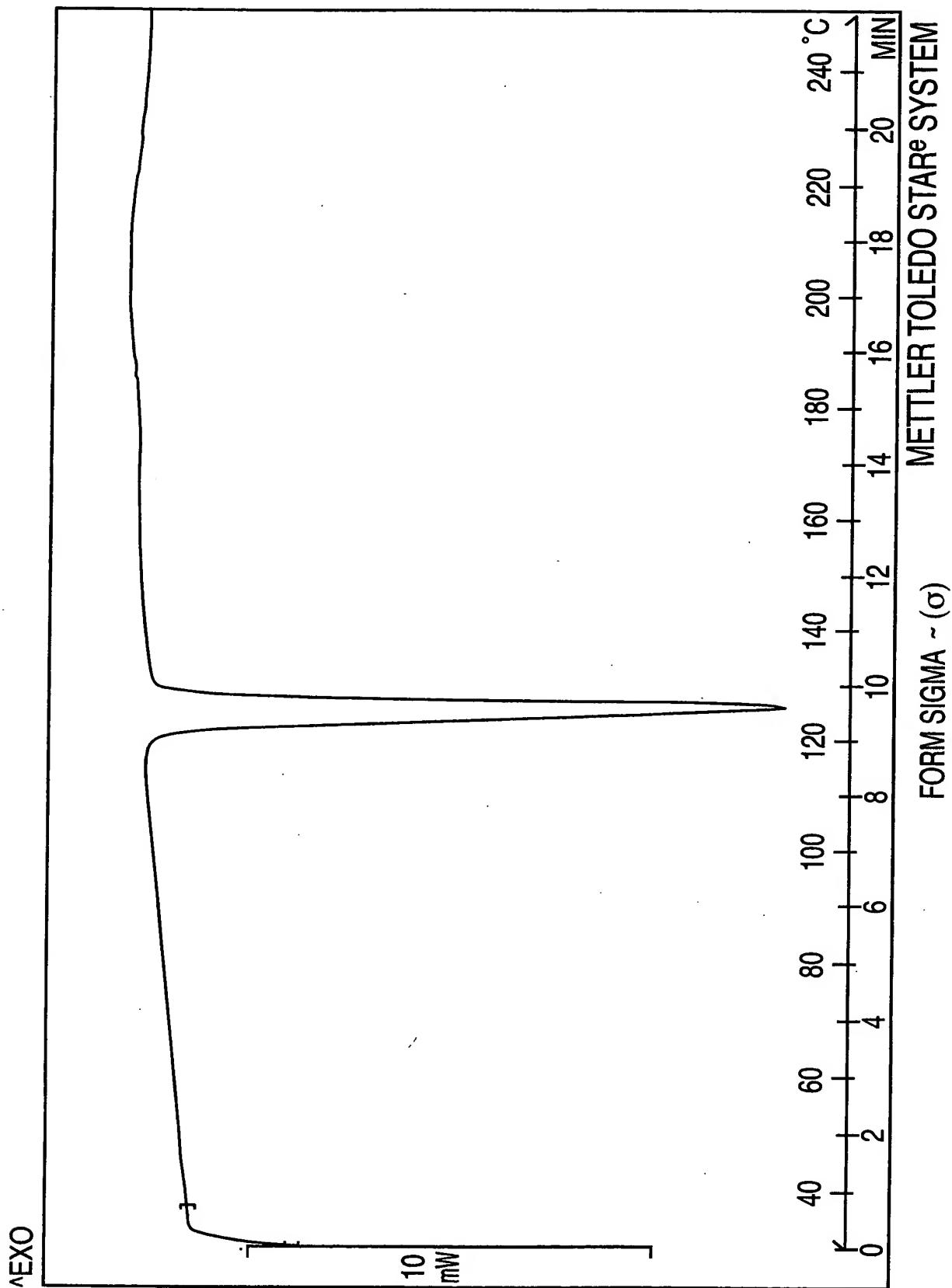
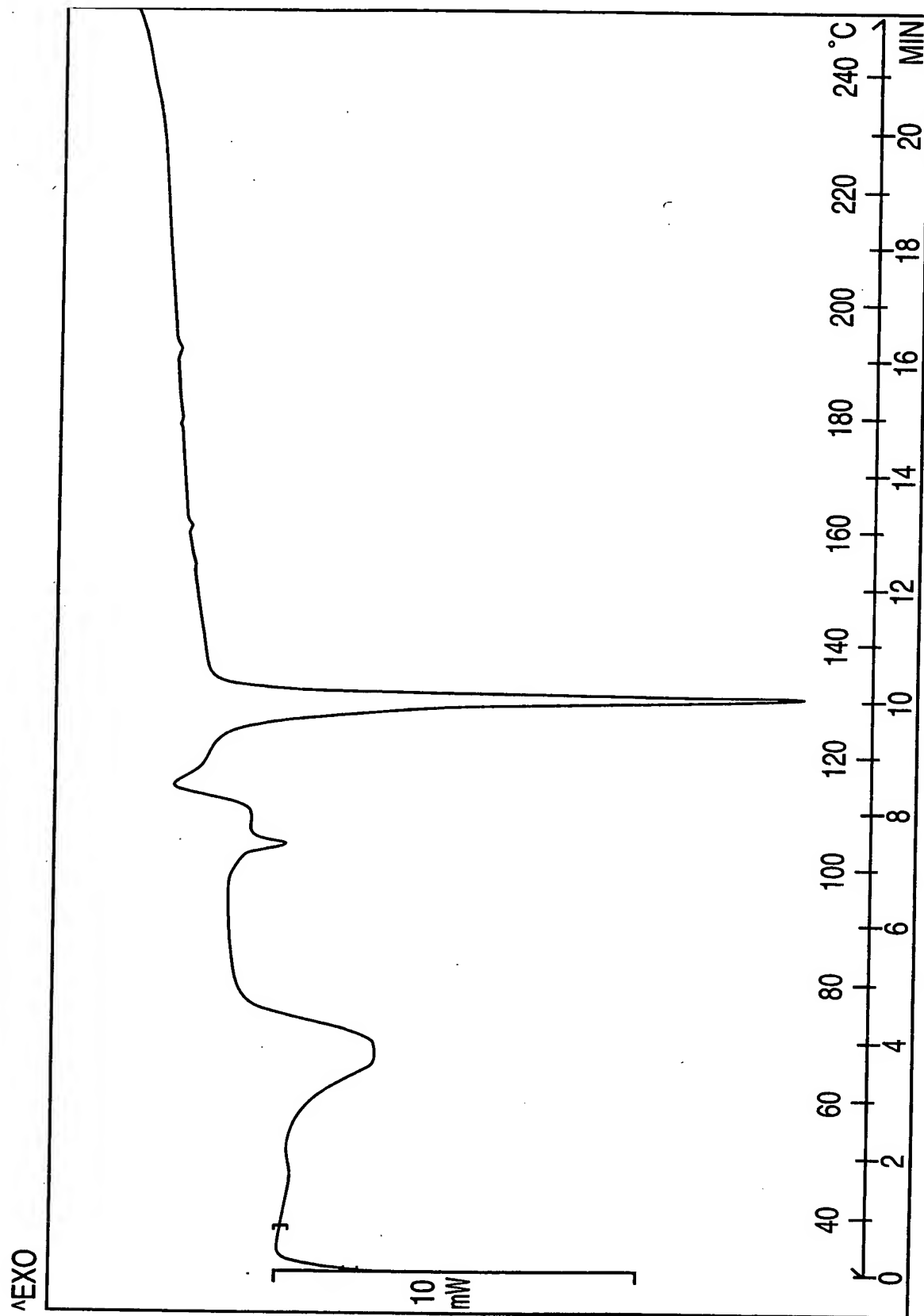


FIG. 61



FORM THETA σ

FIG. 62

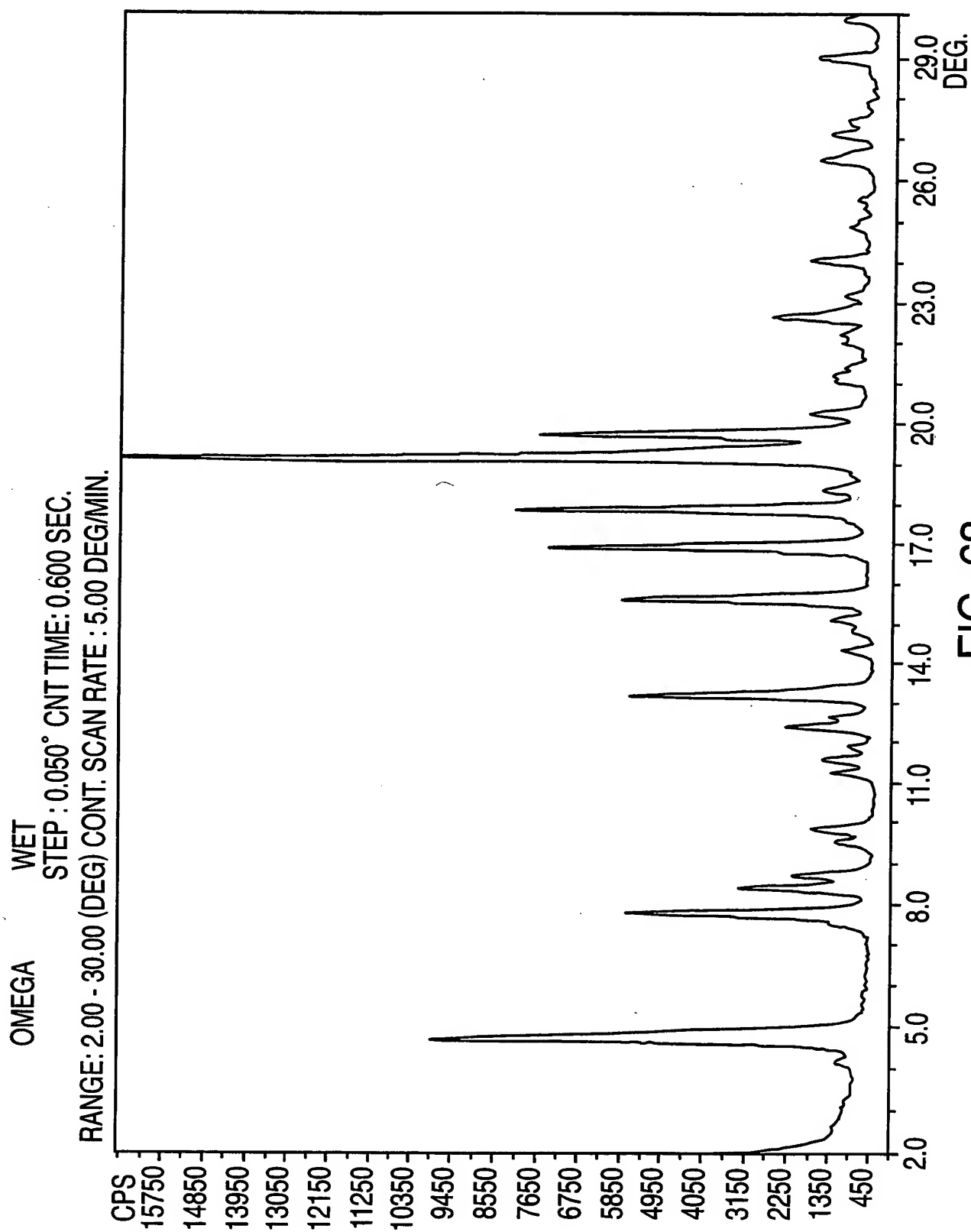


FIG. 63

Comparison between the impurity profile of Nateglinide crystallized in IPA-H₂O and Nateglinide in Methanol-H₂O

Sample No	Solvent	Impurity profile by RRT [% w/w]						
		D-PA (0.23)	(0.25) (0.46)	(0.80) (0.89)	Ipcha (1.38)	Methyl Ester (1.51)	(1.76)	Isopropyl Ester (2.3)
RL-2155/1	Methanol-H ₂ O	<0.01	0.02	<0.01	0.03	0.02	2.91	0.04
RL-2163/4	IPA-H ₂ O	<0.01	0.04	0.02	0.02	0.01	0.03	0.02

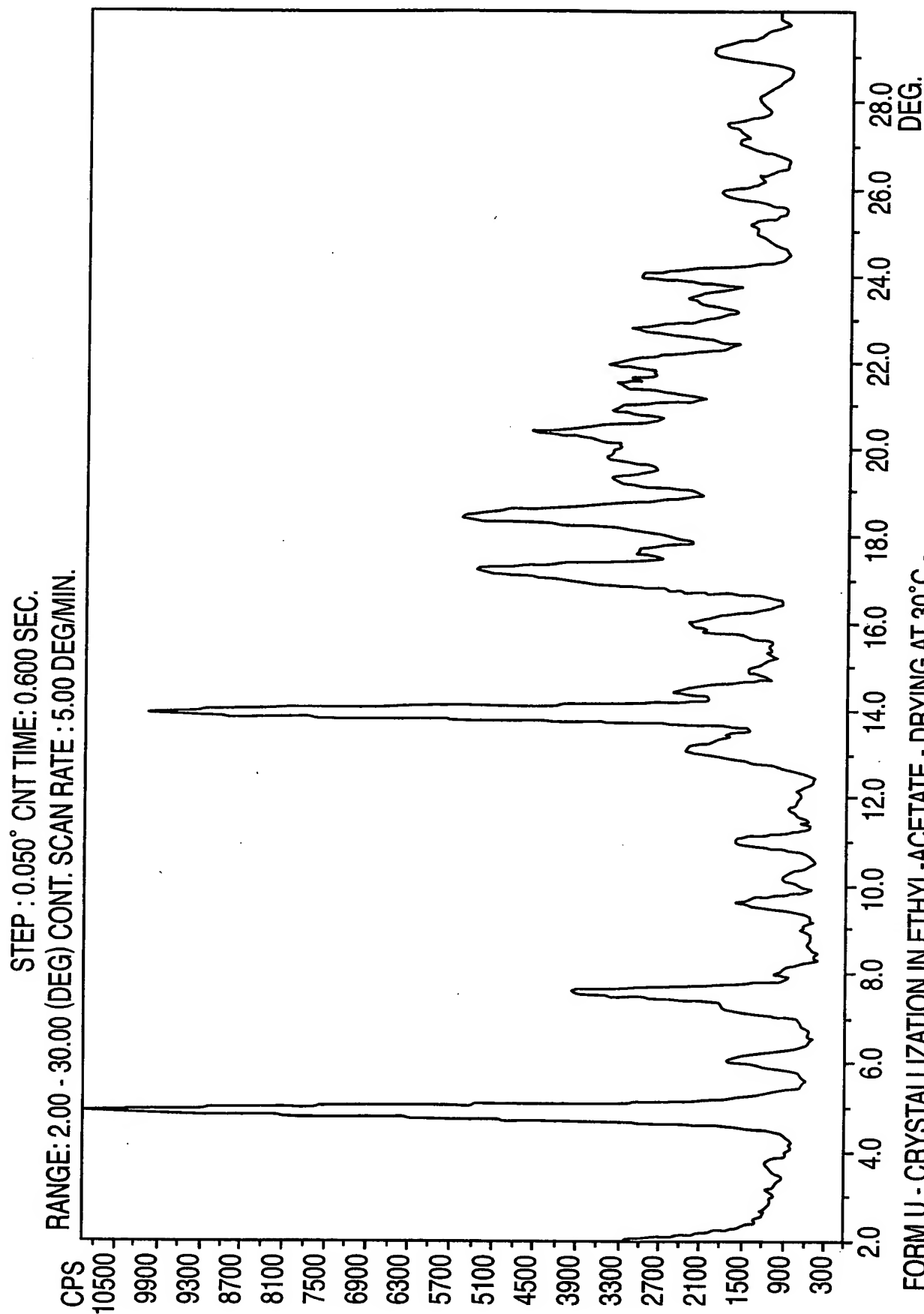
Note: D-PA means D-Phenyl Alanine

Ipcha means Iso propyl cyclohexyl carboxylic acid

Both are the starting materials of the product

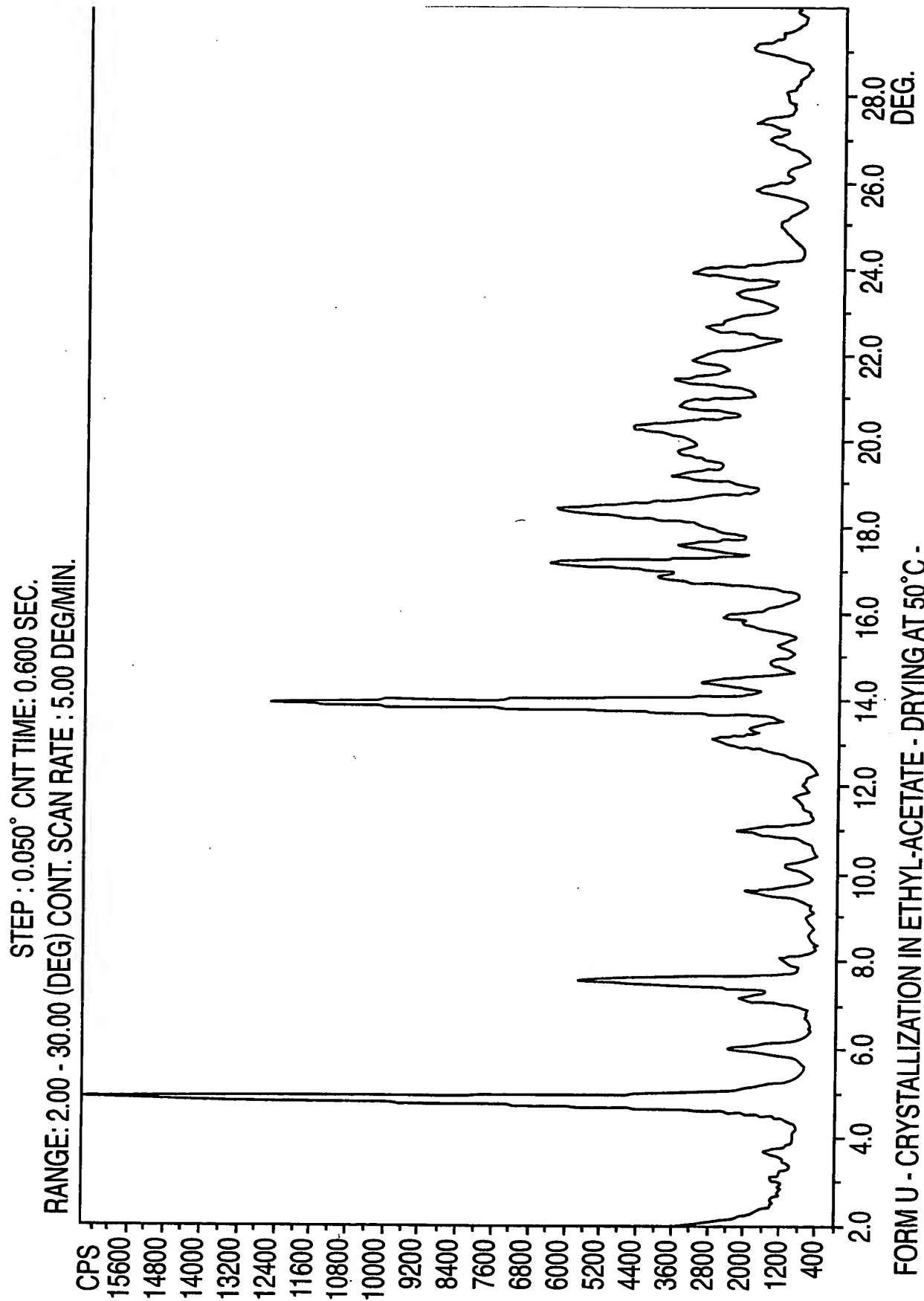
(-)-N-[(trans-4-isopropyl cyclohexane)carbonyl]-D-phenylalanine

FIG. 64



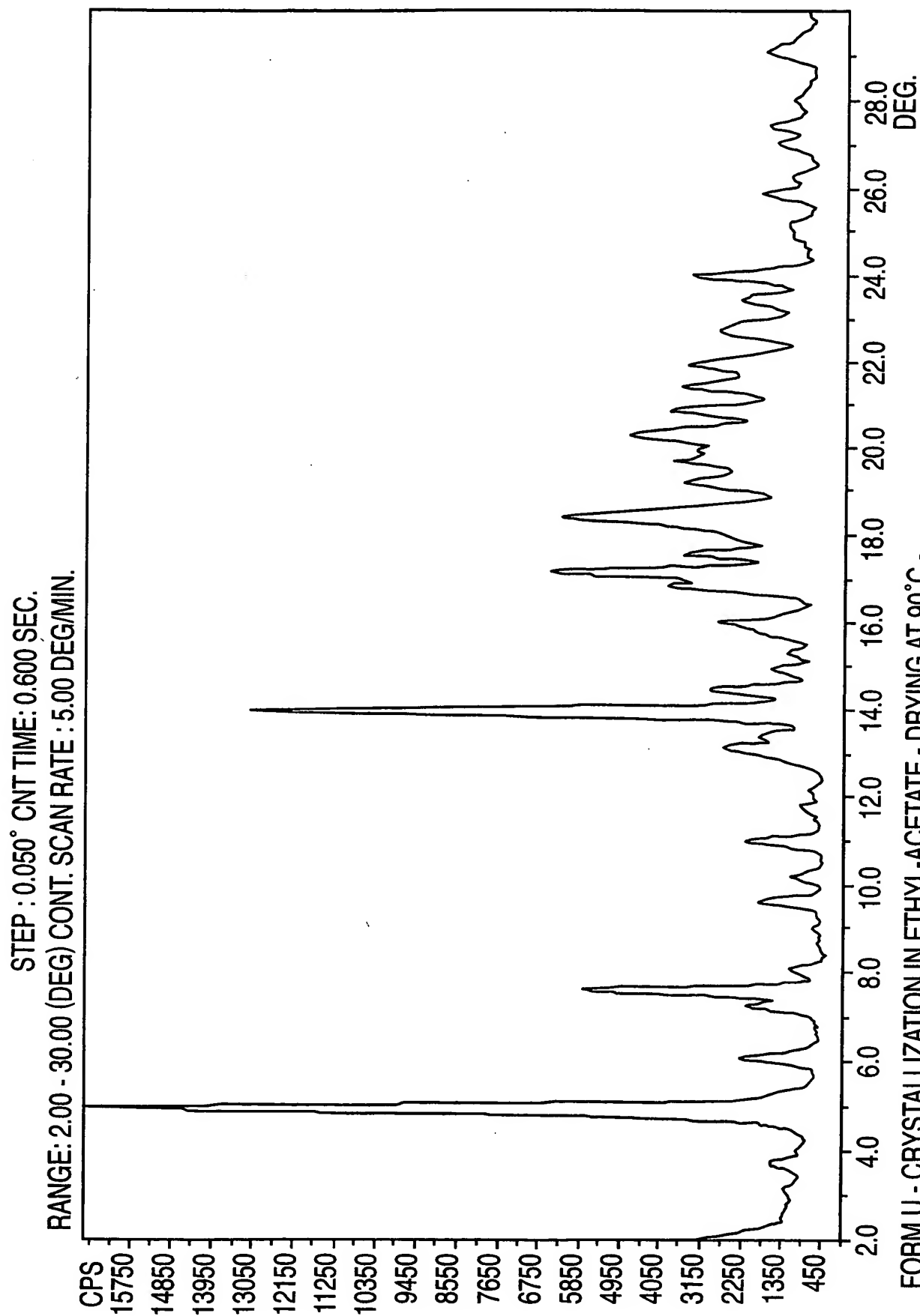
FORM U - CRYSTALLIZATION IN ETHYL-ACETATE - DRYING AT 30°C -
SAMPLE PREPARED ACCORDING TO EXAMPLE 17

FIG. 65



FORM U - CRYSTALLIZATION IN ETHYL-ACETATE - DRYING AT 50°C -
SAMPLE PREPARED ACCORDING TO EXAMPLE 17

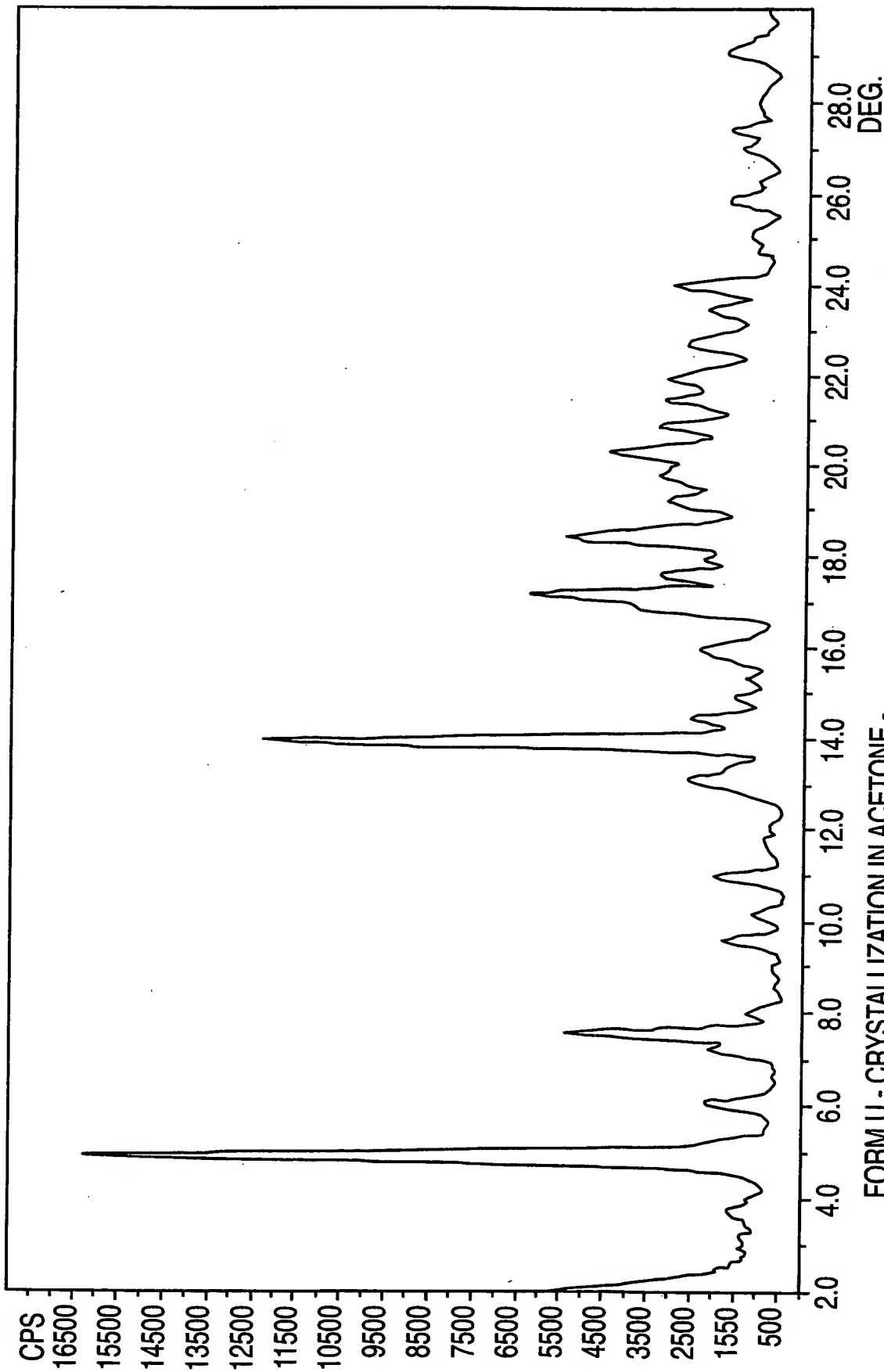
FIG. 66



FORM U - CRYSTALLIZATION IN ETHYL-ACETATE - DRYING AT 90°C -
SAMPLE PREPARED ACCORDING TO EXAMPLE 17

FIG. 67

STEP: 0.050° CNT TIME: 0.600 SEC.
RANGE: 2.00 - 30.00 (DEG) CONT. SCAN RATE: 5.00 DEG/MIN.



FORM U - CRYSTALLIZATION IN ACETONE -
SAMPLE PREPARED ACCORDING TO EXAMPLE 17

FIG. 68